



MODEL G0778 14" INDUSTRIAL BANDSAW MANUAL INSERT

Congratulations on your purchase of the Model G0778 14" Industrial Bandsaw! The Model G0778 is the same machine as the Model G0457 except it has a 1¾ HP motor and is prewired for 110 volt operation. Besides the data sheet, circuit requirements, wiring diagram, and parts list in this insert, all other content in the Model G0457 owner's manual applies to this machine.

▲WARNING: To reduce the risk of serious injury, you **MUST** read and understand this insert—and the entire Model G0457 manual—**BEFORE** assembling, installing, or operating this machine!

If you have any further questions about this manual insert or the differences between the Model G0778 and the Model G0457, contact our Technical Support at (570) 546-9663 or email techsupport@grizzly.com.



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(FOR MODELS MANUFACTURED SINCE 10/14) #BB16885 PRINTED IN TAIWAN



MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0778 14" 1-3/4 HP DELUXE 110V BANDSAW

Product Dimensions:

Weight..... 251 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 29-3/4 x 29-1/2 x 73 in.
 Footprint (Length x Width)..... 21-1/2 x 18-1/4 in.

Shipping Dimensions:

Carton #1

Type..... Cardboard Box
 Content..... Machine
 Weight..... 214 lbs.
 Length x Width x Height..... 52 x 23 x 15 in.
 Must Ship Upright..... No

Carton #2

Type..... Cardboard Box
 Content..... Stand
 Weight..... 70 lbs.
 Length x Width x Height..... 23 x 20 x 27 in.
 Must Ship Upright..... No

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60 Hz
 Prewired Voltage..... 110V
 Full-Load Current Rating..... 15A at 110V, 7.5A at 220V
 Minimum Circuit Size..... 20A at 110V, 15A at 220V
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 7 ft.
 Power Cord Gauge..... 14 AWG
 Plug Included..... Yes
 Included Plug Type..... 5-15 for 110V
 Recommended Plug Type..... 6-15 for 220V
 Switch Type..... ON/OFF Push Button Switch w/Padlock

Motors:

Main

Type..... TEFC Capacitor-Start Induction
 Horsepower..... 1.75 HP
 Phase..... Single-Phase
 Amps..... 15A at 110V, 7.5A at 220V
 Speed..... 1725 RPM
 Power Transfer..... Poly-V Belt Drive
 Bearings..... Sealed & Permanently Lubricated



Main Specifications:

Main Specifications

Bandsaw Size.....	14 in.
Max Cutting Width (Left of Blade).....	13-3/8 in. (34cm)
Max Cutting Width (Left of Blade) w/Fence.....	10-1/2 in. (27cm)
Max Cutting Height (Resaw Height).....	10 in.
Blade Speeds.....	3000 FPM

Blade Information

Standard Blade Length.....	106 in.
Blade Length Range.....	105-3/4 – 107-1/4 in.
Blade Width Range.....	1/8 – 3/4 in.
Type of Blade Guides.....	Ball Bearing
Guide Post Adjustment Type.....	Rack & Pinion
Has Quick-Release.....	Yes

Table Information

Table Length.....	19-3/4 in.
Table Width.....	14-3/16 in.
Table Thickness.....	1-1/2 in.
Table Tilt.....	Left 8, Right 45 deg.
Table Tilt Adjustment Type.....	Manual
Floor-to-Table Height.....	42-1/4 in.
Fence Locking Position.....	Front
Fence is Adjustable for Blade Lead.....	Yes
Resaw Fence Attachment Included.....	Yes
Miter Gauge Included.....	Yes

Construction Materials

Table.....	Precision-Ground Cast Iron
Trunnion.....	Cast Iron
Fence.....	Deluxe Extruded Aluminum
Base/Stand.....	Pre-Formed Steel
Frame/Body.....	Pre-Formed Steel
Wheels.....	Computer-Balanced Cast Iron
Tire.....	Rubber
Wheel Cover.....	Pre-Formed Steel
Paint Type/Finish.....	Powder Coated

Other Related Information

Wheel Diameter.....	14 in.
Wheel Width.....	1-1/8 in.
Number of Dust Ports.....	1
Dust Port Size.....	4 in.
Compatible Mobile Base.....	D2057A

Other Specifications:

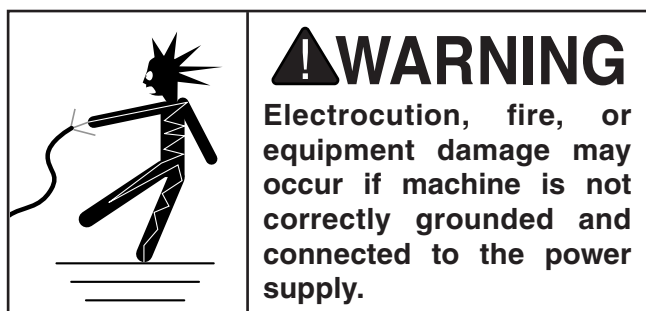
Country of Origin.....	Taiwan
Warranty.....	1 Year
Approximate Assembly & Setup Time.....	45 Minutes
Serial Number Location.....	ID Label on Upper Cover
ISO 9001 Factory.....	Yes
CSA, ETL, or UL Certified/Listed.....	No



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 110V..... 15 Amps

Full-Load Current Rating at 220V 7.5 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

! CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

Circuit Requirements for 110V

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 20 Amps
Plug/Receptacle NEMA 5-15

Circuit Requirements for 220V

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

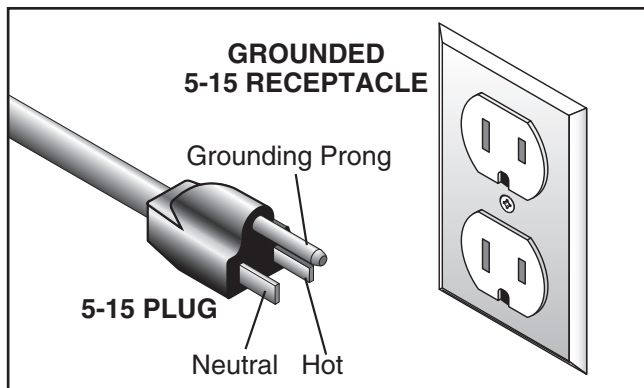
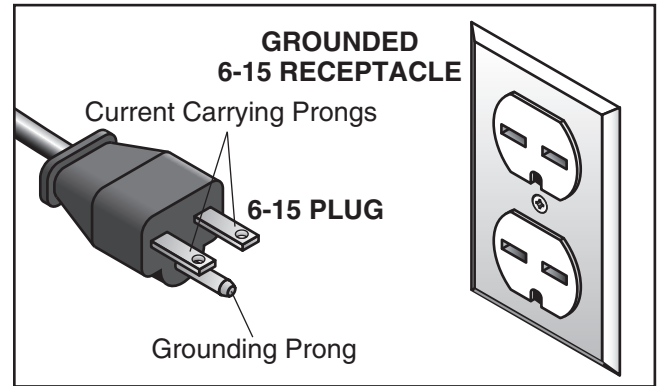
Nominal Voltage 220V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 6-15



Grounding Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.



Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

⚠ CAUTION

SHOCK HAZARD!

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

- Minimum Gauge Size at 110V12 AWG**
- Minimum Gauge Size at 220V 14 AWG**
- Maximum Length (Shorter is Better).....50 ft.**

For 220V operation: The plug specified under “Circuit Requirements for 220V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.



Voltage Conversion

The voltage conversion **MUST** be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of rewiring the main motor and installing the correct plug. A wiring diagram is provided on **Page 7** for your reference.

Items Needed	Qty
• Wrench 7mm	1
• Electrical Tape.....	As Needed
• Plug 6-15.....	1
• Wire Stripper	As Needed

To convert Model G0778 to 220V:

1. DISCONNECT MACHINE FROM POWER!
2. Cut off included plug.
3. Open main motor junction box, then remove wire nuts indicated in **Figure 1**.

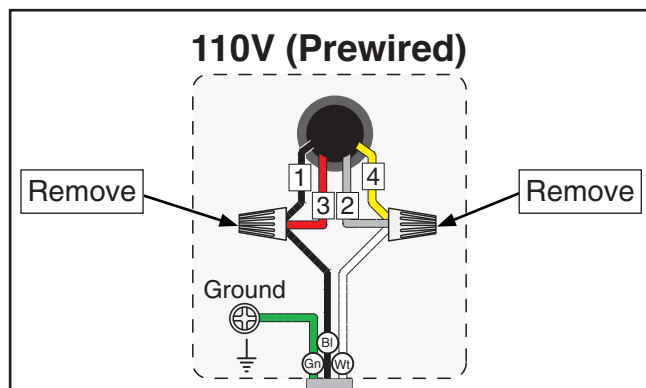


Figure 1. Location of components to be removed and loosened.

4. Connect the main motor wires, as shown in **Figure 2**, with wire nuts. Once snug, wrap electrical tape around each wire nut and the connected wires, to reduce the likelihood of the wire nut vibrating loose during motor operation.

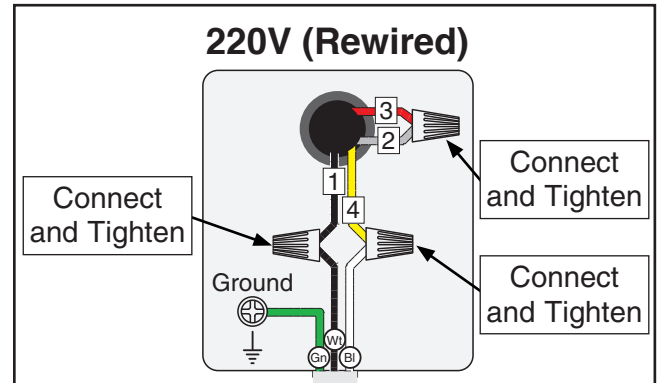


Figure 2. Motor wires repositioned for 220V.

5. Close and secure the motor junction box.
6. Install a 6-15 plug on the end of the cord, according to the instructions and wiring diagrams provided by the plug manufacturer.

—If the plug manufacturer did not include instructions, the wiring of a generic NEMA 6-15 plug is illustrated on **Page 7**.



Accessories

⚠ WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

T26403—The Missing Shop Manual: Bandsaw

Dedicated to providing integral information about woodworking tools and techniques that other manuals overlook, the books in this series contain safety facts, explanations about basic project set up, and tips for maximizing tool performance. In Bandsaw, you will find out how to best utilize this essential workshop tool, and how to get the most for your money by getting the most from your equipment. Filled with clear diagrams and instructions, this pocket sized durable manual is ideal for quick reference in the workshop. 112 pages, soft cover.

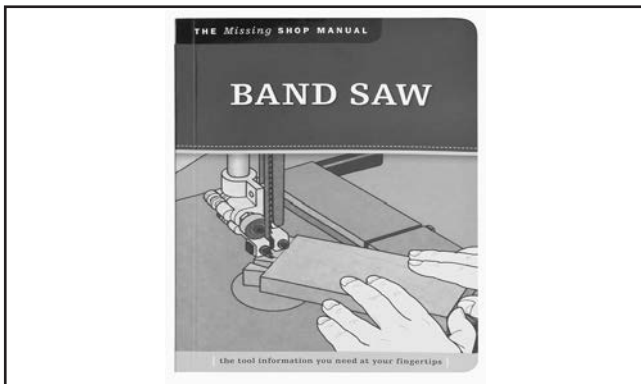


Figure 3. The Missing Shop Manual: Bandsaw.

T26783—New Complete Guide to Band Saws

This essential guide to woodworking's most versatile tool includes a thorough analysis on everything needed to know in order to purchase, set up, use, and maintain a band saw. This book details what woodworkers need to know before purchasing a saw - included the eight questions to ask before buying a used saw - along with topics such as a part-by-part overview of every component of the saw, techniques of set up and alignment, choosing the right blade, and understanding hand positioning to provide any woodworker with the most complete guide to a band saw. Special sections are devoted to band saw accessories, how to deal with common problems, and how to maintain a band saw to keep it running effectively and efficiently for years to come. 200 pages with full color photos.

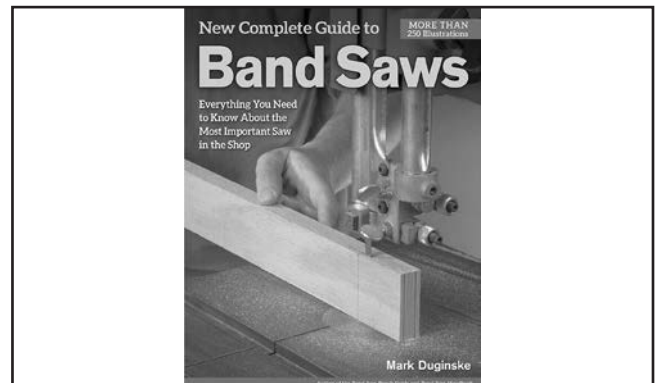


Figure 4. New Complete Guide to Band Saws.

order online at www.grizzly.com or call 1-800-523-4777



T26402—The Bandsaw Book

Comprehensive, up-to-date guide with practical information on set up, tuning, choosing blades, and both basic and advanced techniques. Includes information on the anatomy of a bandsaw, choosing the right one for you, how to select the correct blades for your saw and applications, and how to maintain it to keep it running for years to come. 201 pages, soft cover.

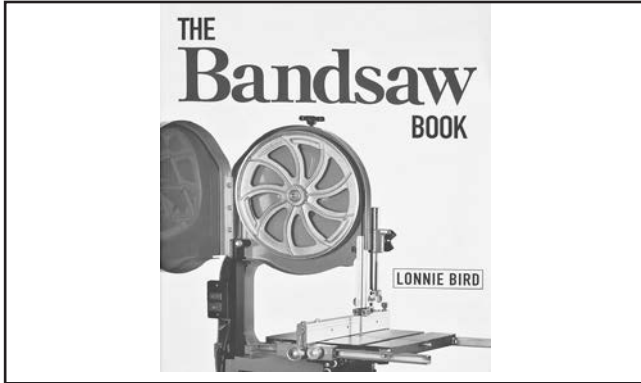


Figure 5. The Bandsaw Book.

G0710—1 HP Wall Hanging Dust Collector

Mount this 1 HP Dust Collector to your wall and keep precious floor space free of clutter. With 537 CFM, this Dust Collector will handle just about any dust producing machine in your shop in a point-of-use, dedicated setup. A simple mounting bracket allows you to hang this dust collector on the wall, or mount it to a bench or the floor. Very versatile!



Figure 6. Model G0710 1 HP Wall Hanging Dust Collector

T26401—Success With Bandsaws

One of the most accessible workshop power tools is also one of the most versatile: the bandsaw. And this new entry in the popular Success with series explores the many creative possibilities of floor-standing, stand-mounted, and portable bench-top models. With these practical instructions and color photographs, woodworkers can quickly master basic skills such as ripping, cutting angles, and mirror cutting, then practice advanced procedures like making dovetail, mortise and tenon joints and cutting variable-curve edges—and even making their own money-saving jigs and templates. There's also basic information on bandsaw anatomy, blade selection, initial set up, routine and periodic maintenance, dust control techniques, and workshop safety. 176 pages.

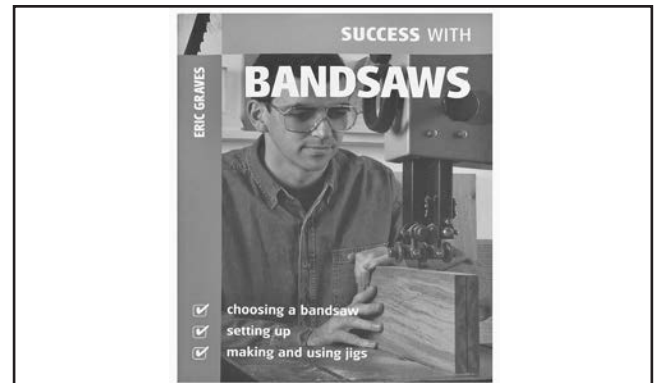


Figure 7. Success With Bandsaws.



Electrical

PUSH BUTTON SWITCH
(viewed from behind)

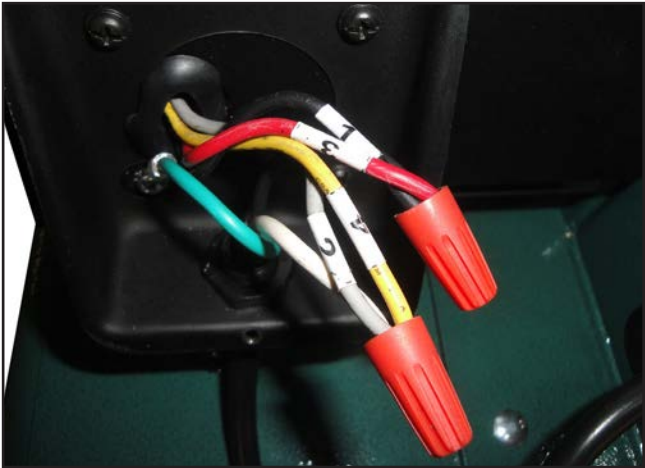
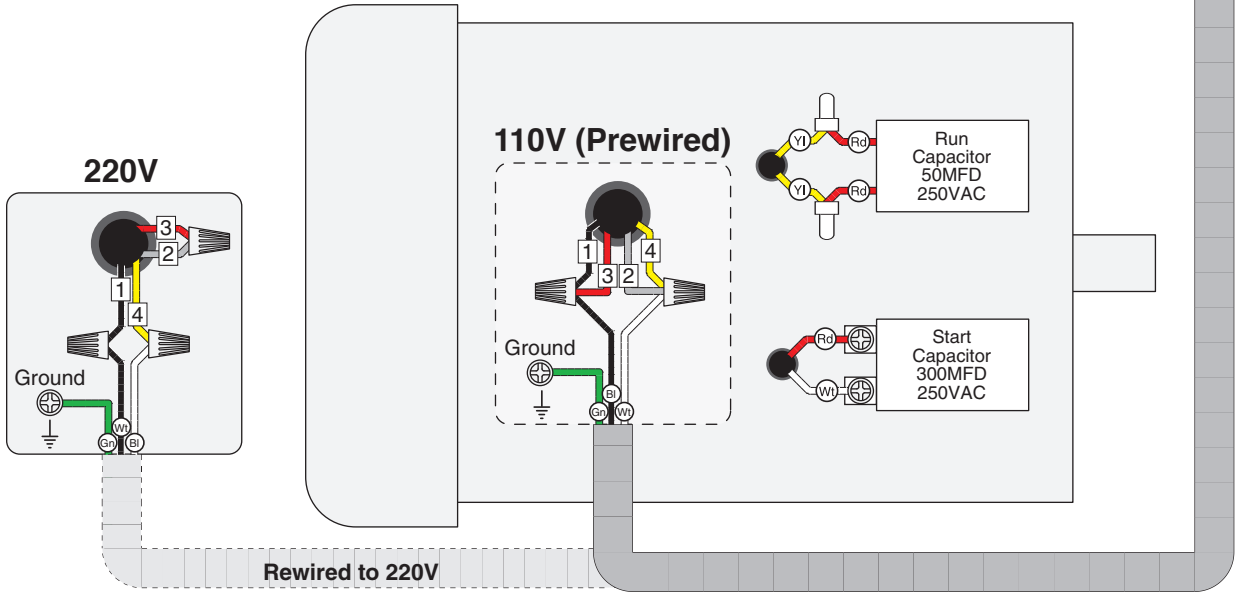
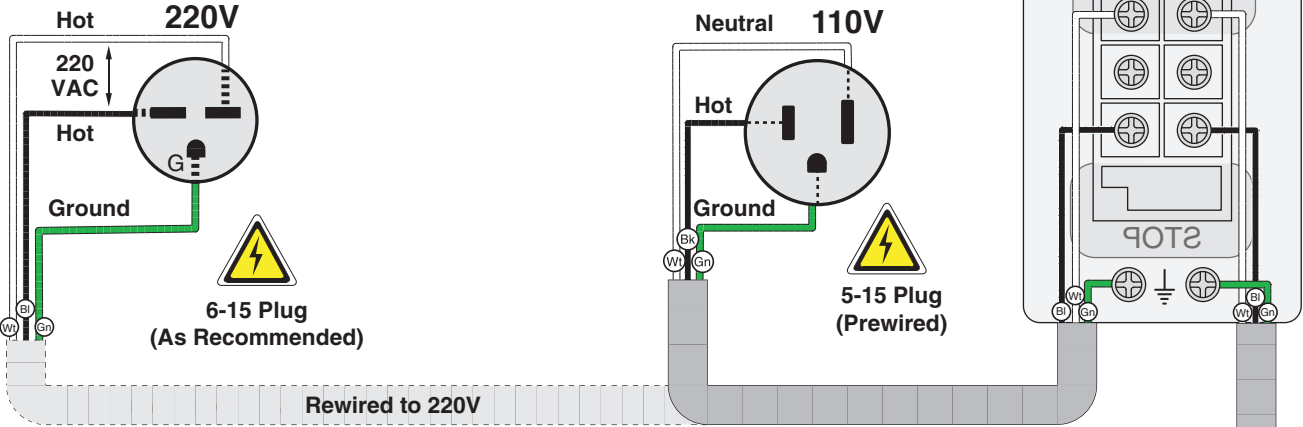


Figure 8. 110V motor wiring.

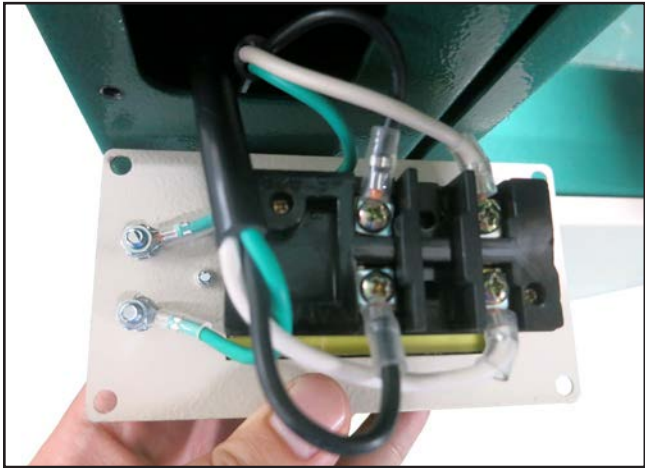
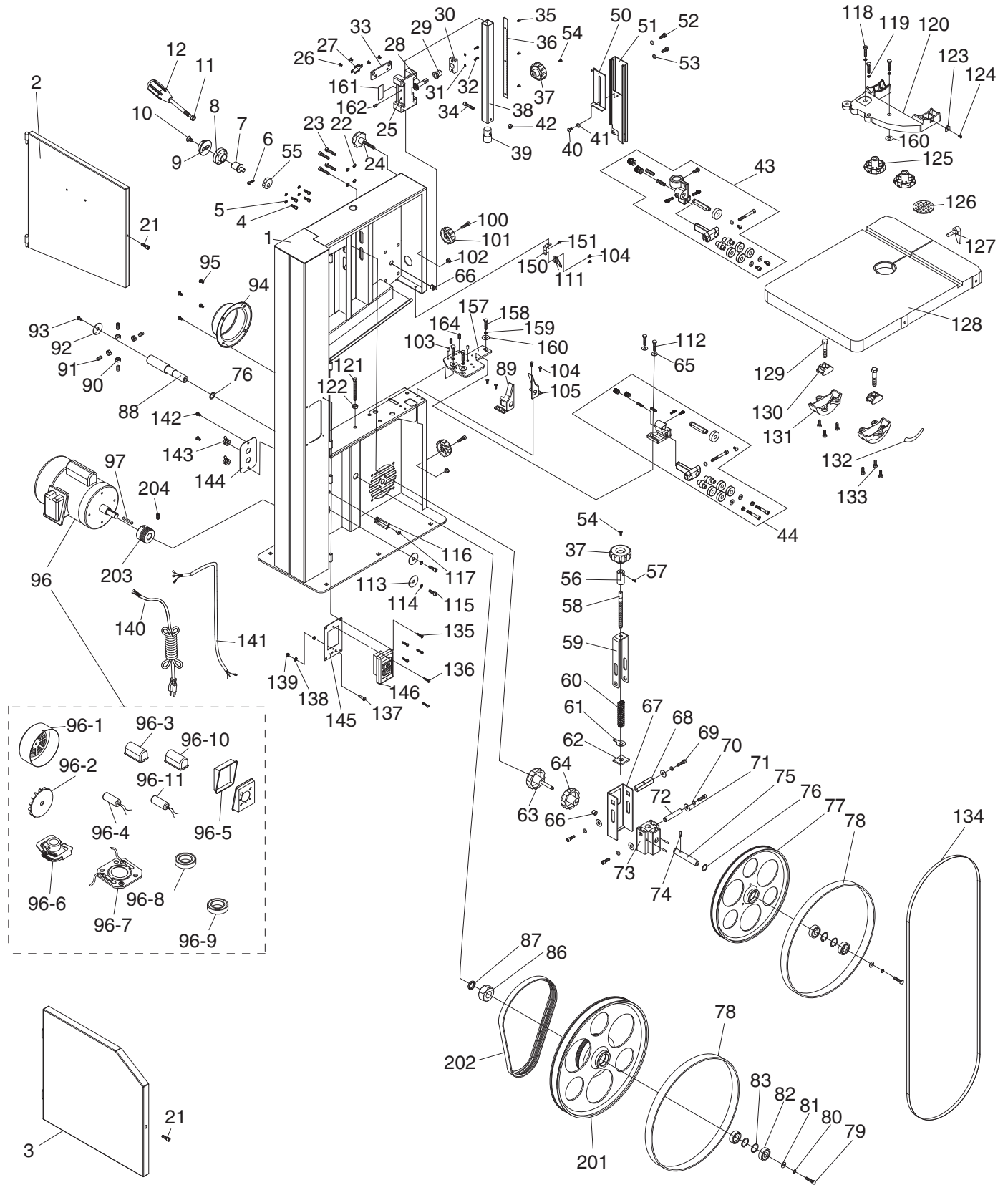


Figure 9. Push button switch wiring.



Main Parts Breakdown



Main Parts List

REF	PART #	DESCRIPTION
1	P0778001	BODY
2	P0778002	UPPER WHEEL DOOR
3	P0778003	LOWER WHEEL DOOR
4	P0778004	CAP SCREW M6-1 X 10
5	P0778005	LOCK WASHER 6MM
6	P0778006	CAP SCREW M5-.8 X 12
7	P0778007	BIAS SHAFT
8	P0778008	BIAS SHAFT CLAMP SEAT
9	P0778009	TENSION ADJUSTMENT HUB
10	P0778010	CAP SCREW M8-1.25 X 20
11	P0778011	HEX NUT M8-1.25
12	P0778012	TENSION HANDLE
21	P0778021	CAP SCREW M6-1 X 10
22	P0778022	LOCK WASHER 8MM
23	P0778023	CAP SCREW M8-1.25 X 20
24	P0778024	LOCK KNOB M8-1.25 X 20
25	P0778025	UPPER GUIDE POST SUPPORT
26	P0778026	FLAT HD SCR M4-.7 X 6
27	P0778027	SPRING TENSIONER
28	P0778028	ADJUSTMENT GEAR SHAFT
29	P0778029	BUSHING
30	P0778030	GEAR SHAFT BRACKET
31	P0778031	LOCK WASHER 6MM
32	P0778032	CAP SCREW M6-1 X 10
33	P0778033	COVER PLATE
34	P0778034	CAP SCREW M6-1 X 35
35	P0778035	FLAT HD SCR M4-.7 X 6
36	P0778036	RACK
37	P0778037	HAND KNOB M10-1.5
38	P0778038	GUIDE POST
39	P0778039	CHANGE SHAFT
40	P0778040	PHLP HD SCR M6-1 X 12
41	P0778041	WASHER 6MM PLASTIC
42	P0778042	LOCK NUT M6-1
43	P0778043	UPPER BLADE GUIDE ASSEMBLY
44	P0778044	LOWER BLADE GUIDE ASSEMBLY
50	P0778050	SLIDING BLADE GUARD
51	P0778051	BLADE GUARD
52	P0778052	HEX BOLT M6-1 X 8
53	P0778053	FLAT WASHER 6MM
54	P0778054	FLANGE SCREW M6-1 X 8
55	P0778055	CAM
56	P0778056	LOCK COLLAR
57	P0778057	SET SCREW M5-.8 X 5
58	P0778058	TENSION ADJUSTMENT SCREW
59	P0778059	ADJUSTMENT SCREW BRACKET
60	P0778060	COMPRESSION SPRING
61	P0778061	TENSION INDICATOR
62	P0778062	THREADED PLATE
63	P0778063	LOCK KNOB M8-1.25 X 45
64	P0778064	KNOB M8-1.25
65	P0778065	FLAT WASHER 6MM
66	P0778066	PULL NUT M8-1.25
67	P0778067	BRACKET

REF	PART #	DESCRIPTION
68	P0778068	SQUARE SHAFT 12 X 12MM
69	P0778069	CAP SCREW M8-1.25 X 20
70	P0778070	LOCK WASHER 8MM
71	P0778071	FLAT WASHER 8MM
72	P0778072	SLEEVE
73	P0778073	UPPER WHEEL SHAFT BRACKET
74	P0778074	ROLL PIN 5 X 35
75	P0778075	UPPER WHEEL SHAFT
76	P0778076	WAVY WASHER 15 X 22MM
77	P0778077	UPPER WHEEL
78	P0778078	WHEEL TIRE
79	P0778079	HEX BOLT M8-1.25 X 16
80	P0778080	LOCK WASHER 8MM
81	P0778081	FLAT WASHER 8MM
82	P0778082	BALL BEARING 620ZZ
83	P0778083	INT RETAINING RING 35MM
86	P0778086	HEX NUT M18-1.5
87	P0778087	LOCK WASHER 18MM
88	P0778088	LOWER WHEEL SHAFT
89	P0778089	LEFT BLADE COVER
90	P0778090	HEX NUT M8-1.25
91	P0778091	SET SCREW M8-1.25 X 20
92	P0778092	SHAFT END CAP
93	P0778093	FLANGE SCREW M5-.8 X 8
94	P0778094	DUST PORT
95	P0778095	FLANGE SCREW M6-1 X 10
96	P0778096	MOTOR 1-3/4 HP 220/110V 1-PH
96-1	P0778096-1	MOTOR FAN COVER
96-2	P0778096-2	MOTOR FAN
96-3	P0778096-3	S CAPACITOR COVER
96-4	P0778096-4	S CAPACITOR 300M 250V 1-1/2 X 2-3/8
96-5	P0778096-5	MOTOR JUNCTION BOX
96-6	P0778096-6	CENTRIFUGAL SWITCH
96-7	P0778096-7	CONTACT PLATE
96-8	P0778096-8	FRONT MOTOR BEARING 6205ZZ
96-9	P0778096-9	REAR MOTOR BEARING 6203ZZ
96-10	P0778096-10	R CAPACITOR COVER
96-11	P0778096-11	R CAPACITOR 50M 250V 1-1/2 X 2-3/8
97	P0778097	KEY 5 X 5 X 20
100	P0778100	CAP SCREW M6-1 X 20
101	P0778101	WHEEL COVER LATCH KNOB 6MM
102	P0778102	LOCK NUT M6-1
103	P0778103	ALIGNMENT PIN
104	P0778104	FLANGE SCREW M5-.8 X 6
105	P0778105	RIGHT BLADE COVER
111	P0778111	POINTER
112	P0778112	HEX BOLT M6-1 X 12
113	P0778113	FLAT WASHER 8MM
114	P0778114	LOCK WASHER 8MM
115	P0778115	CAP SCREW M8-1.25 X 20
116	P0778116	WHEEL BRUSH
117	P0778117	FLANGE SCREW M5-.8 X 8
118	P0778118	HEX BOLT M8-1.25 X 35



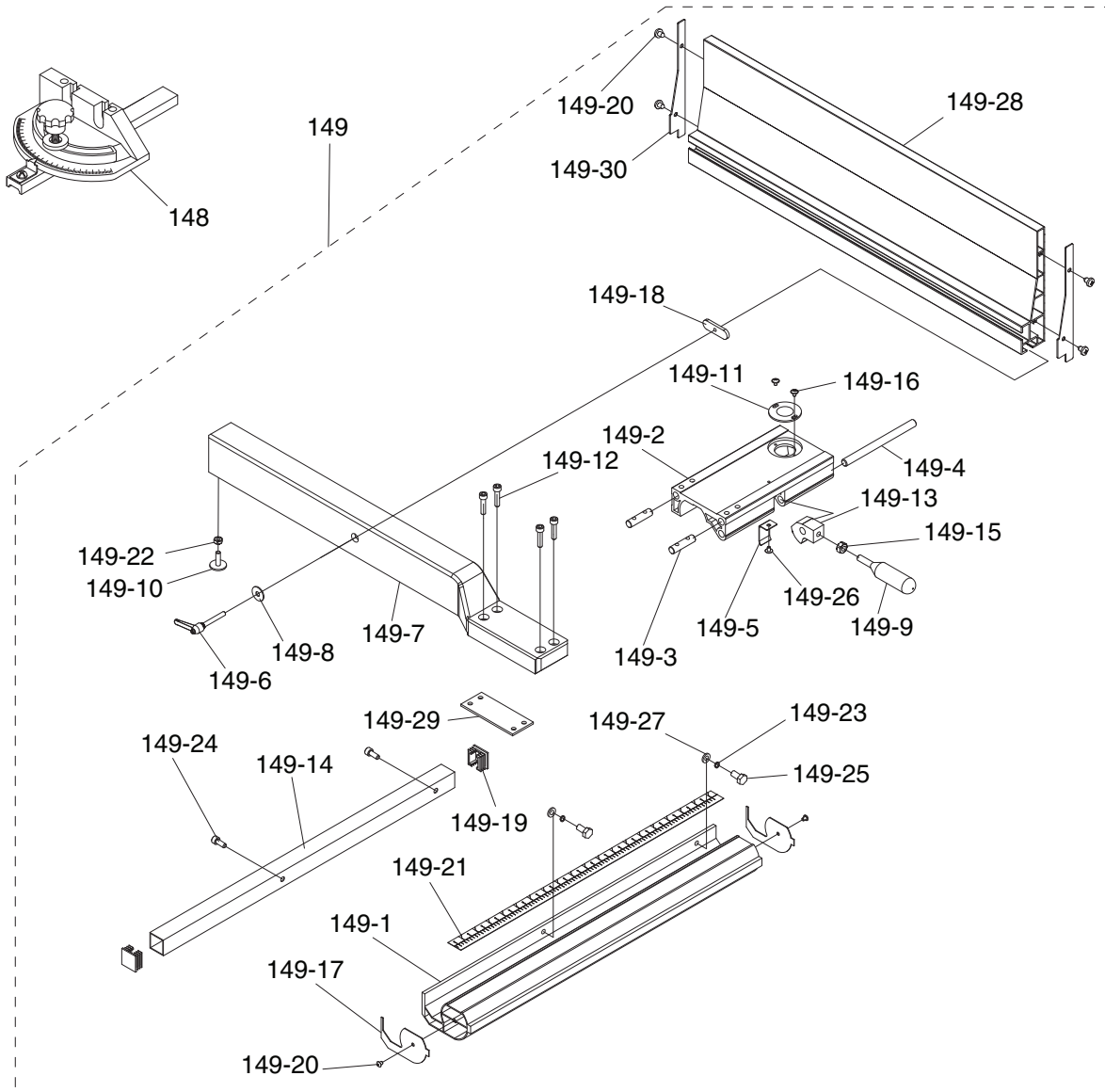
Main Parts List (Continued)

REF	PART #	DESCRIPTION
119	P0778119	LOCK WASHER 8MM
120	P0778120	TRUNNION BRACKET CAST IRON
121	P0778121	HEX BOLT M8-1.25 X 80
122	P0778122	HEX NUT M8-1.25
123	P0778123	POINTER
124	P0778124	PHLP HD SCR M5-.8 X 6
125	P0778125	LOCK KNOB M10-1.5
126	P0778126	TABLE INSERT
127	P0778127	TABLE PIN
128	P0778128	TABLE
129	P0778129	HEX BOLT M10-1.5 X 50
130	P0778130	TRUNNION CLAMP SHOE 1PC
131	P0778131	TRUNNION CAST IRON
132	P0778132	SCALE
133	P0778133	FLANGE BOLT M6-1 X 12
134	P0778134	BLADE 106 X 3/8 X 0.35" 6TPI
135	P0778135	FLANGE SCREW M5-.8 X 8
136	P0778136	PHLP HD SCR M4-.7 X 10
137	P0778137	PHLP HD SCR M5-.8 X 12
138	P0778138	EXT TOOTH WASHER 5MM
139	P0778139	HEX NUT M5-.8

REF	PART #	DESCRIPTION
140	P0778140	POWER CORD 14G 3W 84" 5-15P
141	P0778141	MOTOR CORD 14G 3C
142	P0778142	FLANGE SCREW M5-.8 X 8
143	P0778143	STRAIN RELIEF
144	P0778144	SWITCH BOX REAR PLATE
145	P0778145	SWITCH BOX FRONT PLATE
146	P0778146	ON/OFF SWITCH 110/220V
150	P0778150	POINTER BRACKET
151	P0778151	FLANGE SCREW M5-.8 X 12
157	P0778157	LEVER PLATE
158	P0778158	HEX BOLT M8-1.25 X 20
159	P0778159	LOCK WASHER 8MM
160	P0778160	FLAT WASHER 8MM
161	P0778161	SHIM PLASTIC
162	P0778162	SET SCREW M6-1 X 6
164	P0778164	SET SCREW M8-1.25 X 10
201	P0778201	WHEEL LOWER ASSEMBLY
202	P0778202	RIBBED BELT 200J5
203	P0778203	MOTOR PULLEY
204	P0778204	SET SCREW M6-1 X 10



Fence Parts Breakdown

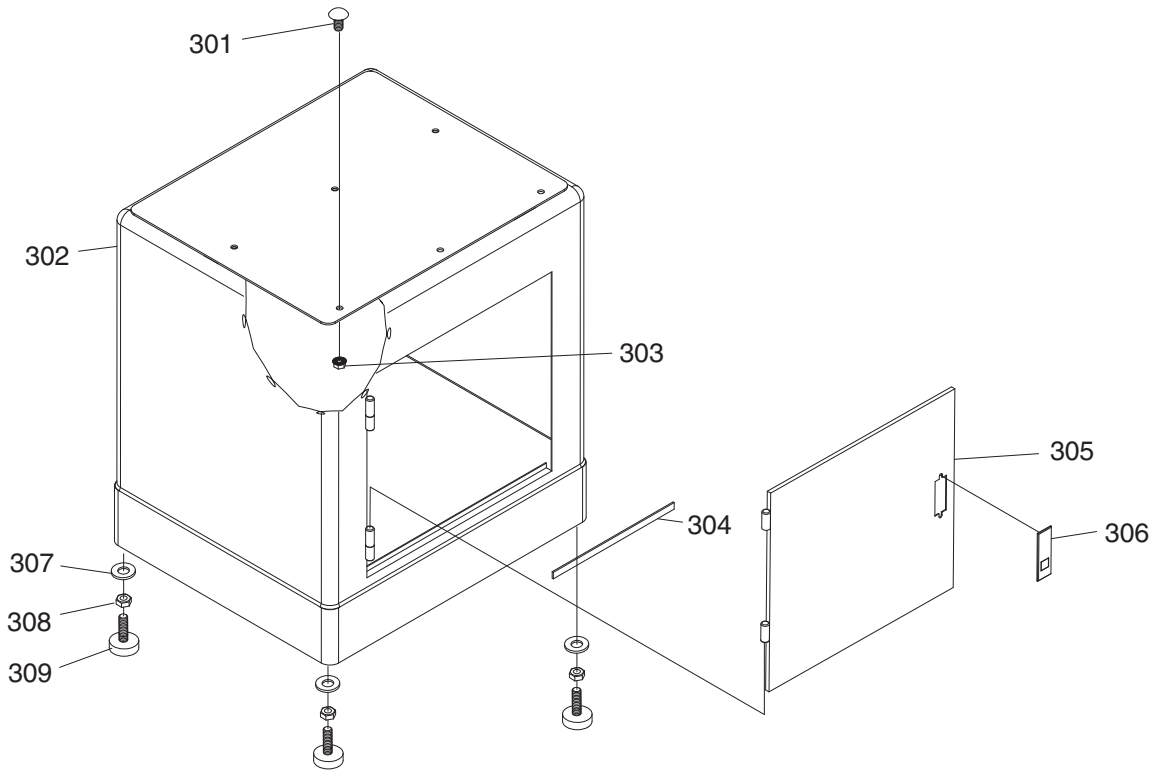


REF	PART #	DESCRIPTION
148	P0778148	MITER GAUGE ASSEMBLY
149	P0778149	RESAW FENCE ASSEMBLY
149-1	P0778149-1	FRONT FENCE RAIL 540MM
149-2	P0778149-2	FENCE BASE
149-3	P0778149-3	FENCE SUPPORT MOUNTING ROD
149-4	P0778149-4	LOCK ROD
149-5	P0778149-5	SPRING PIECE
149-6	P0778149-6	LOCK HANDLE ASSEMBLY M8-1.25 X 44
149-7	P0778149-7	FENCE SUPPORT 505MM
149-8	P0778149-8	FLAT WASHER 8MM
149-9	P0778149-9	LOCK HANDLE
149-10	P0778149-10	FENCE REAR STANDOFF
149-11	P0778149-11	SCALE WINDOW
149-12	P0778149-12	CAP SCREW M6-1 X 25
149-13	P0778149-13	LOCK CAM
149-14	P0778149-14	REAR FENCE RAIL

REF	PART #	DESCRIPTION
149-15	P0778149-15	HEX NUT M8-1.25
149-16	P0778149-16	FLANGE SCREW M4-.7 X 6
149-17	P0778149-17	FRONT RAIL END CAP
149-18	P0778149-18	FENCE MOUNTING PLATE
149-19	P0778149-19	REAR RAIL END CAP
149-20	P0778149-20	TAP SCREW M3.5 X 8
149-21	P0778149-21	SCALE
149-22	P0778149-22	HEX NUT M6-1
149-23	P0778149-23	LOCK WASHER 6MM
149-24	P0778149-24	CAP SCREW M6-1 X 16
149-25	P0778149-25	HEX BOLT M6-1 X 20
149-26	P0778149-26	FLANGE SCREW M4-.7 X 8
149-27	P0778149-27	FLAT WASHER 6MM
149-28	P0778149-28	FENCE 505MM ALUMINUM
149-29	P0778149-29	FENCE SUPPORT MOUNTING PLATE
149-30	P0778149-30	FENCE END CAP



Stand Parts Breakdown

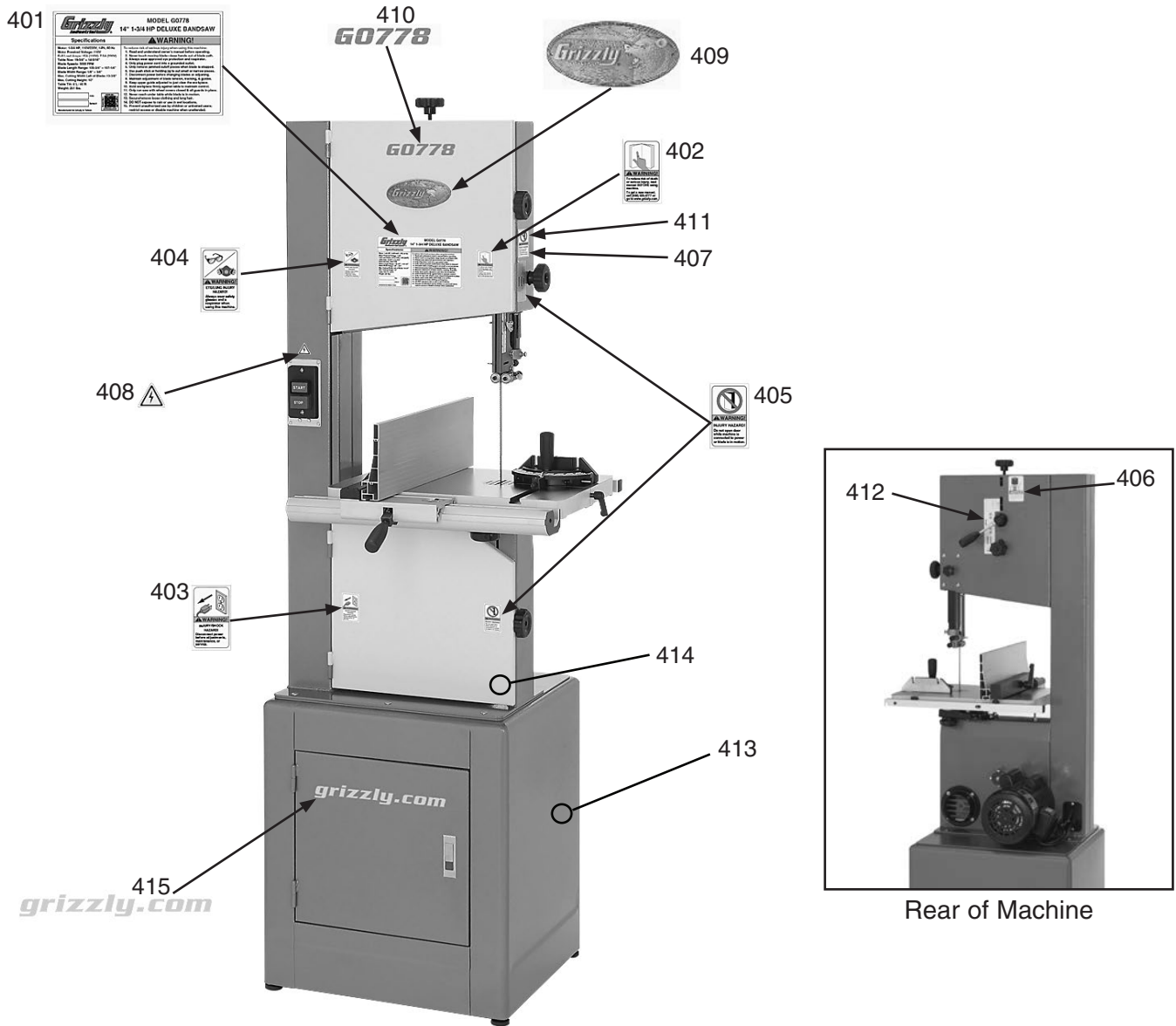


REF	PART #	DESCRIPTION
301	P0778301	CARRIAGE BOLT M8-1.25 X 20
302	P0778302	STAND
303	P0778303	FLANGE NUT M8-1.25
304	P0778304	FOAM TAPE
305	P0778305	DOOR

REF	PART #	DESCRIPTION
306	P0778306	LATCH ASSEMBLY
307	P0778307	FLAT WASHER 3/8
308	P0778308	HEX NUT 3/8-16
309	P0778309	FOOT 3/8-16 X 1-3/4



Labels & Cosmetics



REF	PART #	DESCRIPTION
401	P0778401	MACHINE ID LABEL
402	P0778402	READ MANUAL LABEL
403	P0778403	UNPLUG BANDSAW LABEL
404	P0778404	GLASSES/RESPIRATOR LABEL
405	P0778405	DO NOT OPEN LABEL
406	P0778406	BLADE TENSION NOTICE LABEL
407	P0778407	HANDS NEAR BLADE LABEL
408	P0778408	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
409	P0778409	GRIZZLY NAMEPLATE
410	P0778410	MODEL NUMBER LABEL
411	P0778411	BLADE GUARD ADJ LABEL
412	P0778412	BLADE TENSION SCALE/LABEL
413	P0778413	GRIZZLY GREEN TOUCH-UP PAINT
414	P0778414	GRIZZLY PUTTY TOUCH-UP PAINT
415	P0778415	GRIZZLY.COM LABEL

⚠ WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.



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Grizzly *Industrial, Inc.*®

MODEL G0457 14" INDUSTRIAL BANDSAW OWNER'S MANUAL




C US
252923

COPYRIGHT © AUGUST, 2005 BY GRIZZLY INDUSTRIAL, INC. REVISED NOVEMBER, 2014 (MN)
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
(FOR MACHINES MANUFACTURED SINCE 10/14) #TR7412 PRINTED IN TAIWAN



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

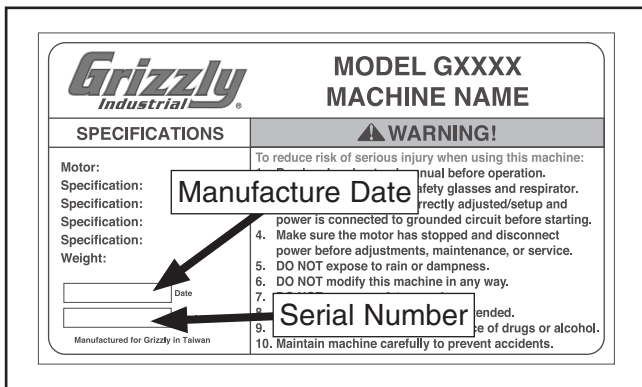
Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs contained inside. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive will be slightly different than what is shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused about a procedure, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com.**

Alternatively, you can call our Technical Support for help. Before calling, please write down the **Manufacture Date** and **Serial Number** stamped into the machine ID label (see below). This information helps us determine if updated documentation is available for your machine.



Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

WARNING

For Your Own Safety Read Instruction Manual Before Operating Bandsaw

- a) Wear eye protection.
- b) Do not remove jammed cutoff pieces until blade has stopped.
- c) Maintain proper adjustment of blade tension, blade guides, and thrust bearings.
- d) Adjust upper guide to just clear workpiece.
- e) Hold workpiece firmly against table.



Identification

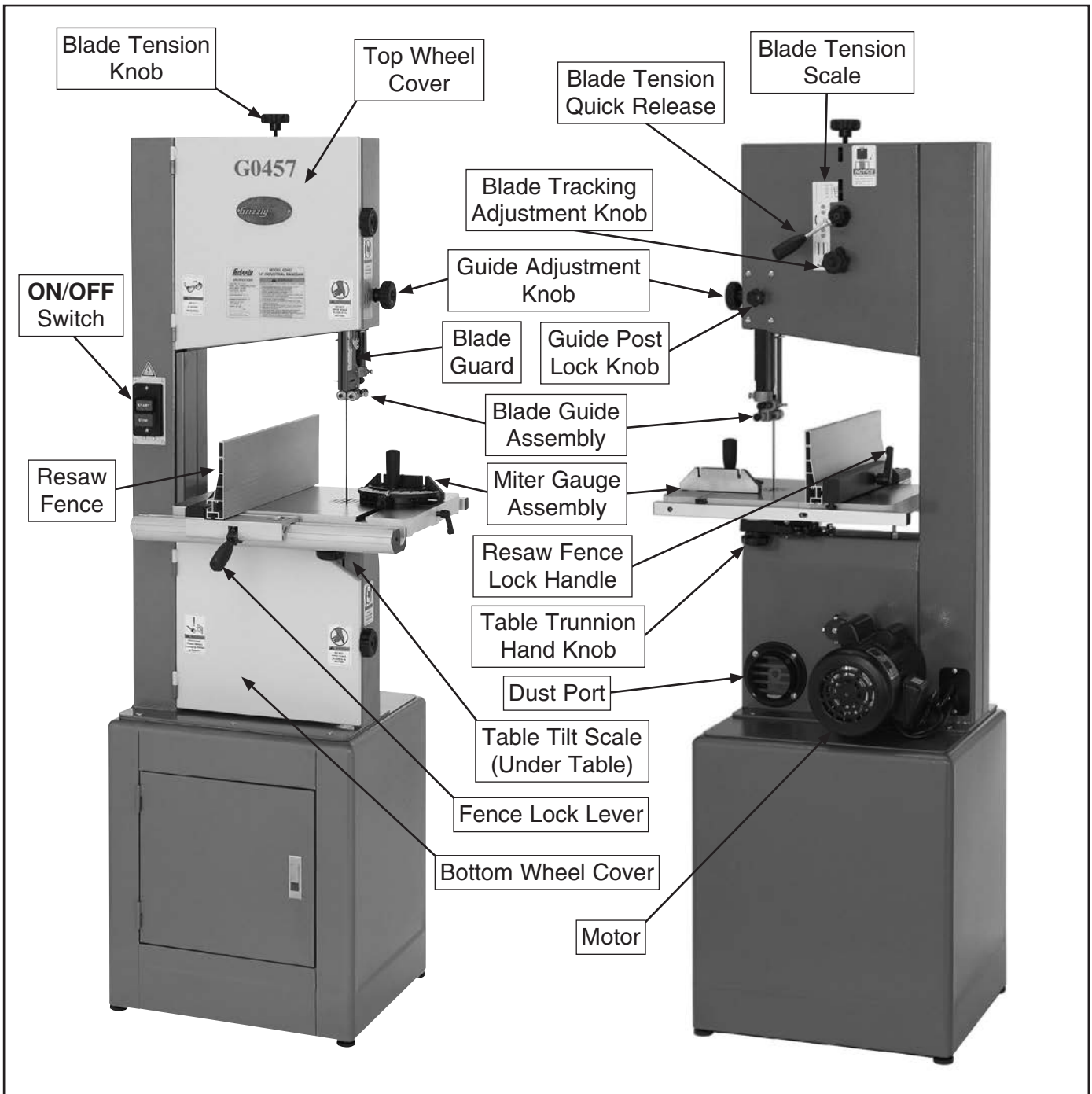


Figure 1. Identification.

NOTICE

If you have never used this type of machine or equipment before, **WE STRONGLY RECOMMEND** that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0457 14" 2 HP DELUXE BANDSAW

Product Dimensions:

Weight..... 251 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 29-3/4 x 29-1/2 x 73 in.
 Footprint (Length x Width)..... 21-1/2 x 18-1/4 in.

Shipping Dimensions:

Carton #1

Type..... Cardboard Box
 Content..... Machine
 Weight..... 214 lbs.
 Length x Width x Height..... 51 x 23 x 14 in.
 Must Ship Upright..... No

Carton #2

Type..... Cardboard Box
 Content..... Stand
 Weight..... 70 lbs.
 Length x Width x Height..... 22 x 19 x 25 in.
 Must Ship Upright..... No

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60 Hz
 Prewired Voltage..... 220V
 Full-Load Current Rating..... 19A at 110V, 9.5A at 220V
 Minimum Circuit Size..... 20A at 110V, 15A at 220V
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 7 ft.
 Power Cord Gauge..... 14 AWG
 Plug Included..... Yes
 Included Plug Type..... 6-15 for 220V
 Recommended Plug Type..... 5-20 for 110V
 Switch Type..... ON/OFF Push Button Switch w/Padlock

Motors:

Main

Type..... TEFC Capacitor-Start Induction
 Horsepower..... 2 HP
 Phase..... Single-Phase
 Amps..... 19A/9.5A
 Speed..... 1725 RPM
 Power Transfer..... Poly-V Belt Drive
 Bearings..... Sealed & Permanently Lubricated



Main Specifications:

Main Specifications

Bandsaw Size.....	14 in.
Max Cutting Width (Left of Blade).....	13-1/2 in.
Max Cutting Width (Left of Blade) w/Fence.....	12-1/4 in.
Max Cutting Height (Resaw Height).....	10 in.
Blade Speeds.....	3000 FPM

Blade Information

Standard Blade Length.....	106 in.
Blade Length Range.....	105-3/4 – 107-1/4 in.
Blade Width Range.....	1/8 – 3/4 in.
Type of Blade Guides.....	Ball Bearing
Guide Post Adjustment Type.....	Rack & Pinion
Has Quick-Release.....	Yes

Table Information

Table Length.....	19-3/4 in.
Table Width.....	14-3/16 in.
Table Thickness.....	1-1/2 in.
Table Tilt.....	Left 8, Right 45 deg.
Table Tilt Adjustment Type.....	Manual
Floor-to-Table Height.....	42-1/4 in.
Fence Locking Position.....	Front
Fence is Adjustable for Blade Lead.....	Yes
Resaw Fence Attachment Included.....	Yes
Miter Gauge Included.....	Yes

Construction Materials

Table.....	Precision Ground Cast Iron
Trunnion.....	Cast Iron
Fence.....	Deluxe Extruded Aluminum
Base/Stand.....	Pre-Formed Steel
Frame/Body.....	Pre-Formed Steel
Wheels.....	Computer-Balanced Cast Iron
Tire.....	Rubber
Wheel Cover.....	Pre-Formed Steel
Paint Type/Finish.....	Powder Coated

Other Related Information

Wheel Diameter.....	14 in.
Wheel Width.....	1-1/8 in.
Number of Dust Ports.....	1
Dust Port Size.....	4 in.
Compatible Mobile Base.....	D2057A

Other Specifications:

Country of Origin.....	Taiwan
Warranty.....	1 Year
Approximate Assembly & Setup Time.....	45 Minutes
Serial Number Location.....	ID Label on Upper Cover
ISO 9001 Factory.....	Yes
CSA, ETL, or UL Certified/Listed.....	Yes



SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

Safety Instructions for Machinery



OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are **NOT** approved safety glasses.



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.



WARNING

Additional Safety Instructions for Bandsaws

BLADE CONDITION. Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to use and are difficult to control. Inspect blades for cracks and missing teeth before each use.

HAND PLACEMENT. Never position fingers or thumbs in line with the cut. Serious personal injury could occur.

GUARDS. Do not operate this bandsaw without the blade guard in place.

BLADE REPLACEMENT. When replacing blades, make sure teeth face toward the workpiece and the blade is properly tensioned before operating.

WORKPIECE HANDLING. Never hold small workpieces with your fingers during a cut. Always support/feed the workpiece with push stick, table support, vise, or some type of clamping fixture.

CUTTING TECHNIQUES. Plan your cuts so you always cut out of the wood. DO NOT back the workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw OFF and wait for the blade to come to a complete stop, and DO NOT twist or put excessive stress on the blade while backing work away.

BLADE SPEED. Allow blade to reach full speed before cutting.

LEAVING WORK AREA. Never leave a machine running and unattended. Allow the bandsaw to come to a complete stop before you leave it unattended.

FEED RATE. Always feed stock evenly and smoothly. DO NOT force or twist blade while cutting, especially when sawing small radii.

WORKPIECE MATERIAL. This machine is designed to cut wood only. It is not designed to cut metal or use cutting fluid.

MAINTENANCE/SERVICE. All inspections, adjustments, and maintenance are to be done with the power OFF and the plug removed from the outlet. Wait for all moving parts to come to a complete stop.

BLADE CONTROL. Do not attempt to stop or slow the blade with your hand or a workpiece. Allow the blade to stop on its own, unless your machine is equipped with a brake.

EXPERIENCING DIFFICULTIES. If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.

WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

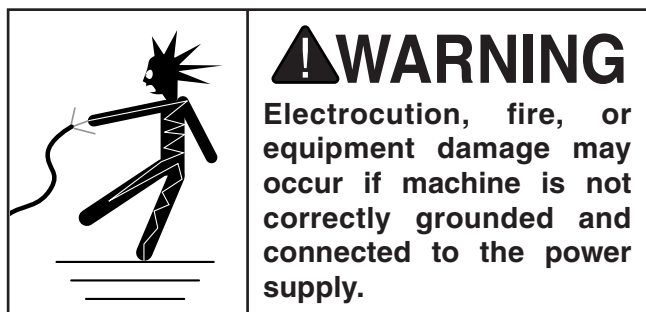
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V 9.5 Amps
Full-Load Current Rating at 110V..... 19 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

⚠ CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

Circuit Requirements for 220V

This machine is prewired to operate on a 220V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V
Cycle 60 Hz
Phase Single-Phase
Circuit Rating 15 Amps
Plug/Receptacle NEMA 6-15

Circuit Requirements for 110V

This machine can be converted to operate on a 110V power supply (refer to **Voltage Conversion** instructions) that has a verified ground and meets the following requirements:

Nominal Voltage 110V
Cycle 60 Hz
Phase Single-Phase
Circuit Rating 20 Amps
Plug/Receptacle NEMA 5-20
Cord “S”-Type, 3-Wire, 12 AWG, 300 VAC



Grounding Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

For 220V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

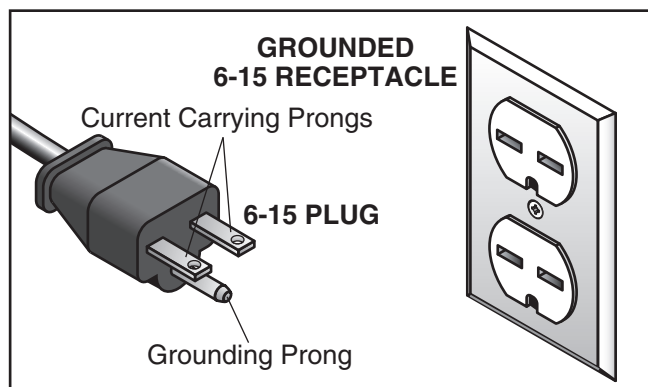


Figure 2. Typical 6-15 plug and receptacle.

For 110V operation: The plug specified in the circuit requirements has a grounding prong that must be attached to the equipment-grounding wire inside the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

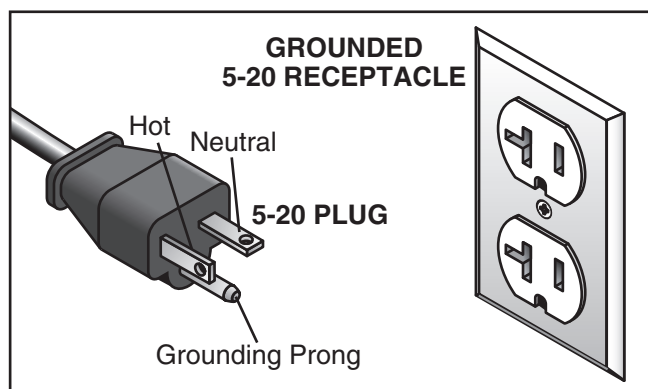


Figure 3. Typical 5-20 plug and receptacle.

!WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.



Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size at 110V 12 AWG
Minimum Gauge Size at 220V 14 AWG
Maximum Length (Shorter is Better)..... 50 ft.

Voltage Conversion

The voltage conversion **MUST** be performed by a qualified electrician. To perform the voltage conversion, replace the power cord, install the correct plug, and rewire the motor to the new voltage, according to the provided wiring diagram on **Page 52**.

Note: *If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. Use the diagram provided inside the motor wiring junction box.*

To convert the machine to 110V:

1. DISCONNECT MACHINE FROM POWER!
2. Replace the power cord with one that matches the cord specifications under **Circuit Recommendations for 110V** on **Page 9**.
3. Replace the 6-15 plug on the power cord with a NEMA 5-20 plug.
4. Re-wire the motor as illustrated in the wiring diagram.

Disabling & Locking Switch

The ON/OFF switch can be disabled and locked by inserting a padlock through the ON button, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

IMPORTANT: Locking the switch with a padlock only restricts its function. It is not a substitute for disconnecting power from the machine when adjusting or servicing.

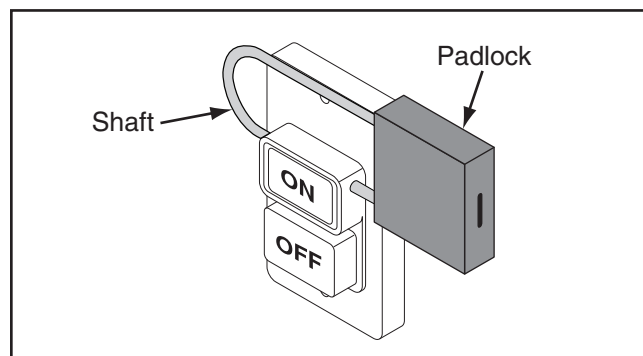


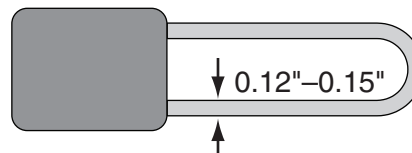
Figure 4. Switch disabled by a padlock.

!WARNING

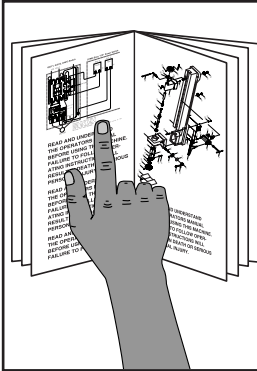
Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, disable and lock the switch before leaving machine unattended! Place key in a well-hidden or secure location.

NOTICE

The padlock shaft diameter is important to the disabling function of the switch. With any padlock used to lock the switch, test the switch after installation to ensure that it is properly disabled.

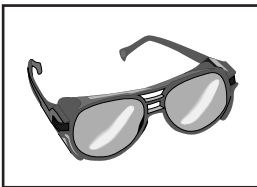


SECTION 3: SETUP



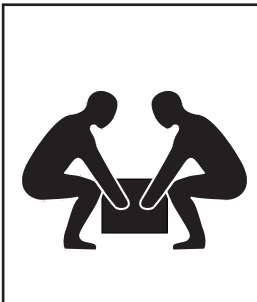
!WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING

Wear safety glasses during the entire setup process!



!WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Safety Glasses (for each person).....	1
• Assistant.....	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed
• Wrenches or Sockets 13mm	2
• Wrench or Socket 10mm.....	1
• Wrench 14mm	1
• Hex Wrench 4mm.....	1
• Hex Wrench 5mm.....	1
• Phillips Screwdriver	1
• Machinist's Square	1
• Ruler	1
• Straightedge	1
• Feeler Gauge 0.016"	1
• Dust Collector.....	1
• Dust Hoses.....	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*







When you are completely satisfied with the condition of your shipment, inventory the contents.









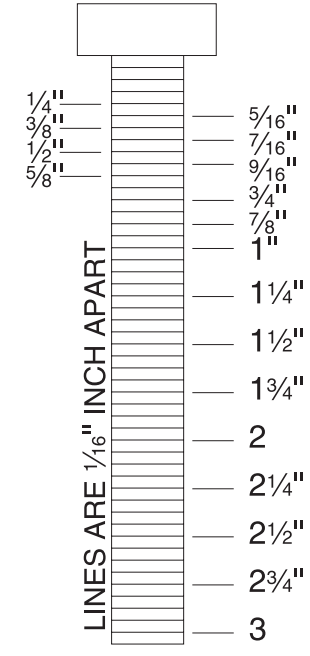
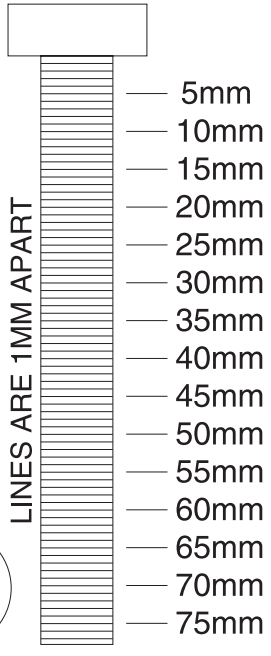
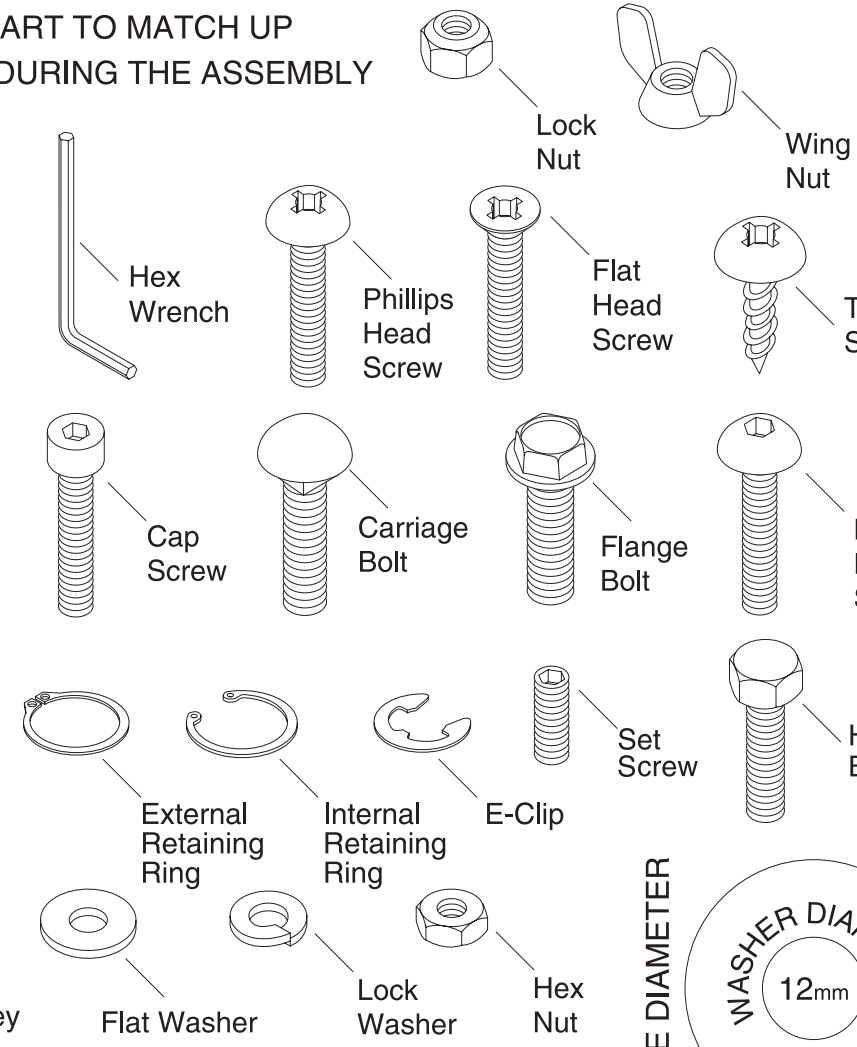
Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS.

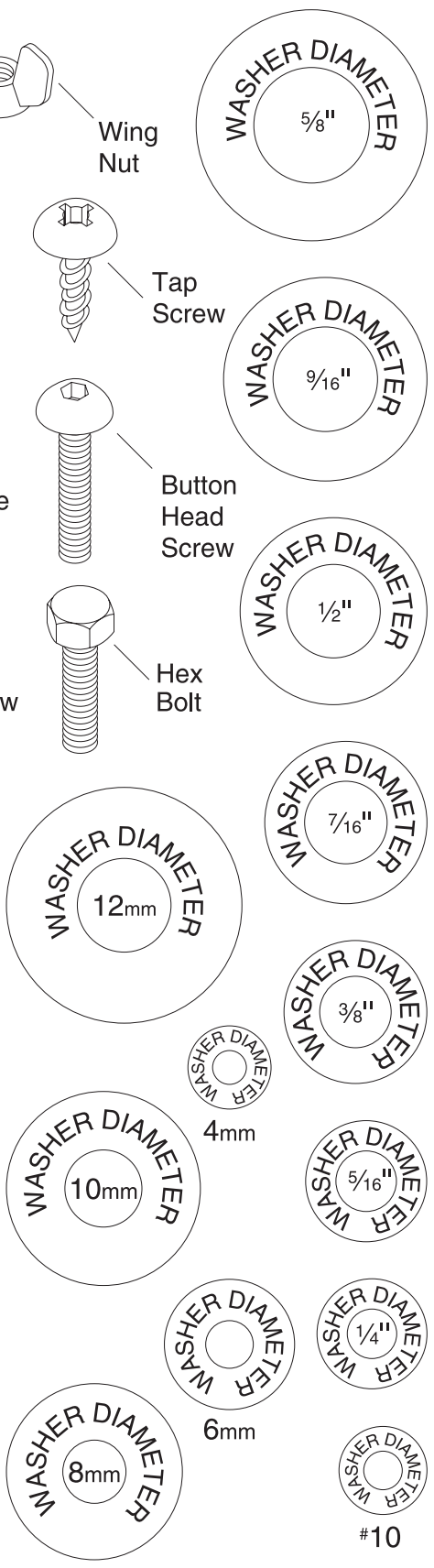
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

-  #10
-  1/4"
-  5/16"
-  3/8"
-  7/16"
-  1/2"

-  4mm
-  6mm
-  8mm
-  10mm
-  12mm
-  16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Contents (Figures 5–6)	Qty
A. Bandsaw Unit	1
B. Cabinet Stand.....	1
C. Feet $\frac{3}{8}$ -16 (Stand)	4
D. Motor	1
E. Blade Tension Knob	1
F. Lever Handle (Quick Release)	1
G. Table.....	1
H. Trunnion Hand Knobs M10-1.5 (Table).....	2
I. Miter Gauge.....	1
J. Fence Assembly.....	1
K. Resaw Fence	1
L. Front Rail	1
M. Rear Rail	1
N. Moving Plate (Fence).....	1
O. Lever Handle w/Nut (Fence).....	1
P. Locking Adjustment Handle (Fence)	1

Hardware (Not shown)

- Cap Screws M8-1.25 x 25 (Motor)..... 2
- Lock Washers 8mm (Motor)
- Fender Washers 8mm (Motor)
- Flat Washers 6mm (Front Rail)
- Lock Washers 6mm (Front Rail).....
- Hex Bolts M6-1 x 20 (Front Rail).....
- Cap Screws M6-1 x 16 (Rear Rail).....
- Flat Washer 8mm (Fence).....
- Flange Screw (Blade Tension Knob).....
- Hex Bolt M8-1.25 x 80 (Positive Stop).....
- Hex Nut M8-1.25 (Positive Stop)
- Carriage Bolts M8-1.25 x 20 (Stand)
- Flange Nuts M8-1.25 (Stand)
- Hex Nut M8-1.25 (Quick Release).....
- Hex Nuts $\frac{3}{8}$ -16 (Feet).....
- Flat Washers 10mm (Feet).....
- Hex Wrench 6mm.....

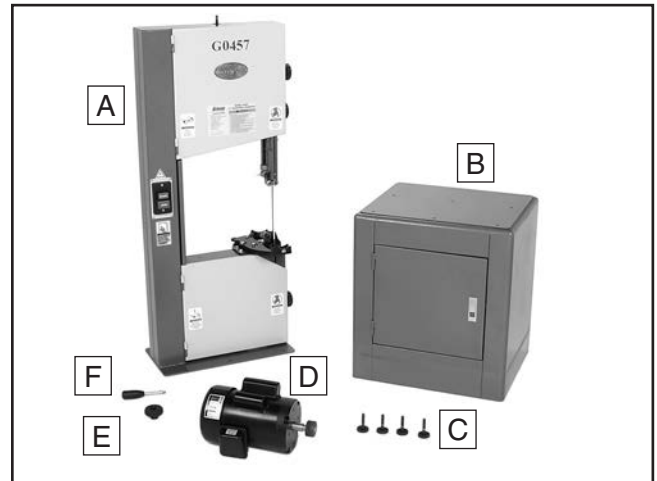


Figure 5. Bandsaw, stand, motor, and components



Figure 6. Table, miter gauge, and hardware bags.

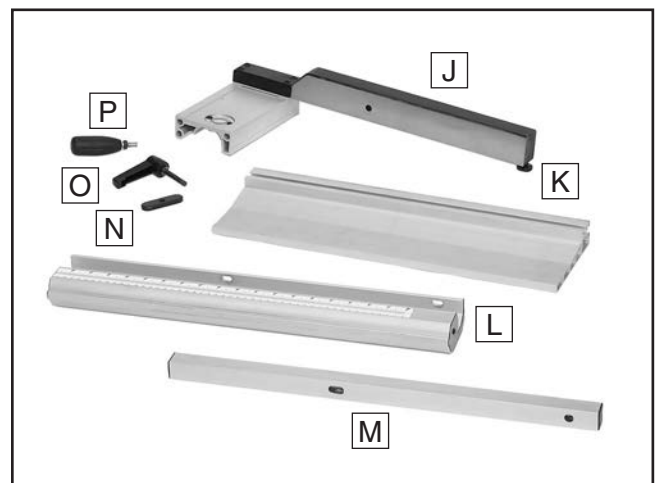



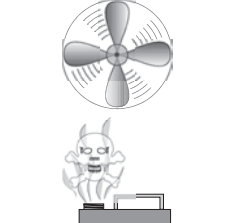
Figure 7. Main fence components.



Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser. For thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>! WARNING Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.</p>
---	--

	<p>! CAUTION Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.</p>
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Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 8** for the minimum working clearances.

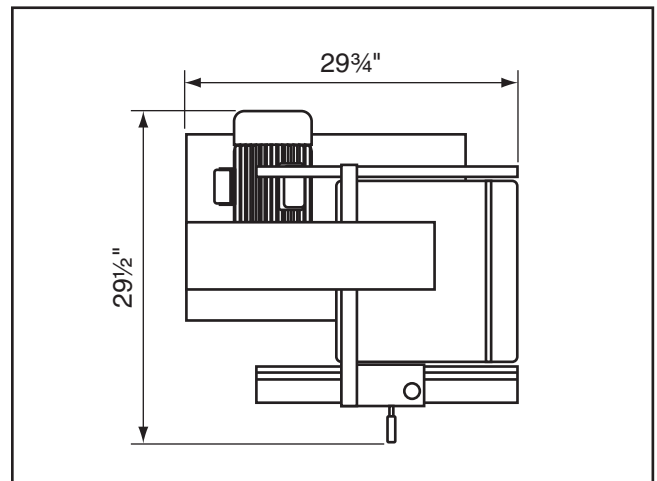
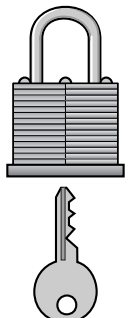


Figure 8. Working clearances.

	<p>! CAUTION Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
--	---



Assembly

To assemble the bandsaw:

1. Turn the cabinet stand upside down and install the feet, as shown in **Figure 9**.



Figure 9. Installing feet on cabinet.

2. Set the cabinet upright, move it to its final position, then adjust the feet so the cabinet is level side-to-side and front-to-back.
3. Secure the position of the feet by tightening the hex nut/washers against the stand.



⚠ WARNING
The bandsaw body is heavy. **DO NOT** over-exert yourself while unpacking or moving your machine—get assistance from another person.

4. With the help of an assistant, set the bandsaw unit onto the stand, align the mounting holes, then open the door on the cabinet stand.
5. Have your assistant hold the bandsaw while you secure the body to the stand with the carriage bolts and flange nuts (**Figure 10**).



Figure 10. Securing the body to the stand.

6. Slide the blade tension knob over the threaded shaft, as shown in **Figure 11**, and secure the knob with the flange screw.

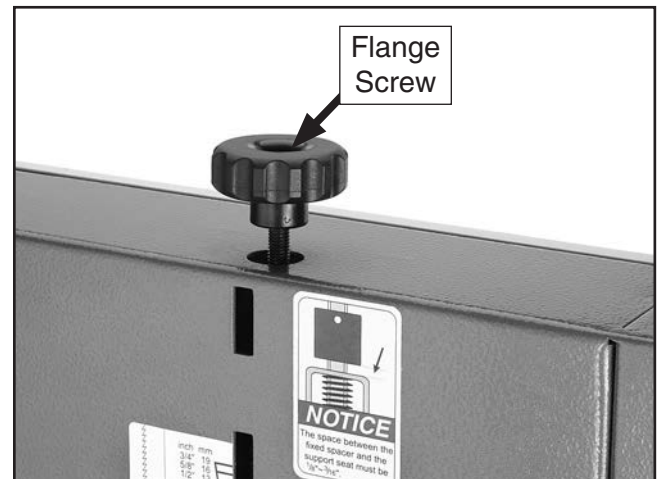


Figure 11. Blade tension knob installed.



7. Thread an M8-1.25 hex nut all the way onto the quick release lever, as shown in **Figure 12**, then thread the lever into the quick release hub and tighten the hex nut against the hub to lock the lever in place.

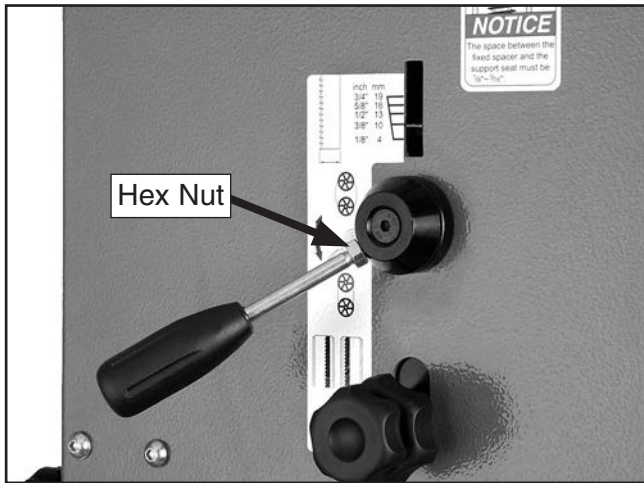


Figure 12. Quick release lever installed.

8. Have an assistant hold the motor in position against the backside of the frame, as shown in **Figure 13**.



Figure 13. Installing motor (outside view).

9. From the inside of the bandsaw, loosely fasten the motor to the body with the cap screws and flat washers, as shown in **Figure 14**.

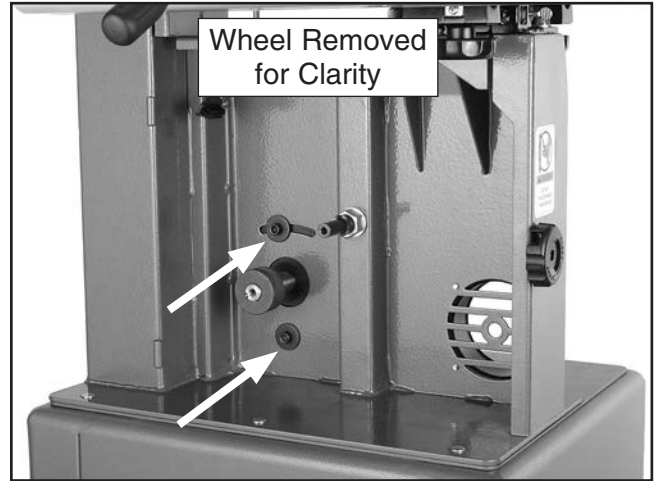


Figure 14. Installing motor (inside view).

10. Place the belt on the pulleys and pivot the motor so the belt is tight, then tighten the cap screws. Refer to **Tensioning V-Belt** on **Page 45** to properly tension the drive belt.
11. Refer to **Wiring** on **Page 51** and wire the motor to the switch cord.
12. Remove the blade from the top and bottom wheels, then remove the table pin and table insert from the table.
13. Place the table bolts through the trunnions.
14. Thread the table trunnion hand knobs onto the table bolts to secure the table (**Figure 15**).

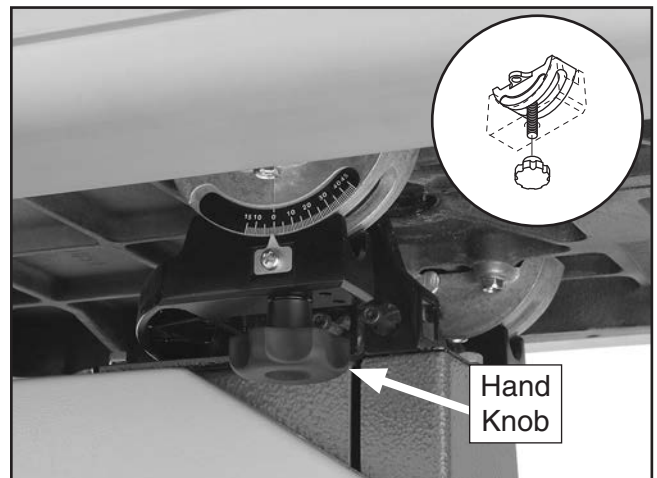


Figure 15. Table installed on trunnions.



15. Replace the blade, and for now, only put enough tension on it to keep it on the wheels.
16. Re-install the table pin and table insert.
17. Fasten the rear rail to the back of the table with the four M6-1 x 16 cap screws, as shown in **Figure 16**.



Figure 16. Rear rail installed.

18. Attach the front rail to the front of the bandsaw table with the two M6-1 x 20 hex bolts, 6mm lock washers and flat washers, as shown in **Figure 17**.



Figure 17. Installed front rail.

19. Install the handle on the fence assembly (**Figure 18**), and tighten the hex nut against the fence pivot block to secure the handle.

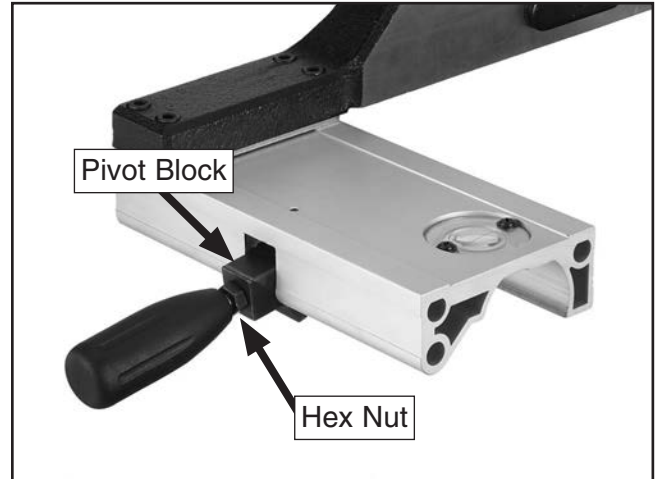


Figure 18. Handle installed on fence assembly.

20. Place the 8mm flat washer on the locking adjustment handle and slide it through the hole in the fence.
21. Thread the moving plate onto the end of the locking adjustment handle threads.
22. Slide the resaw fence over the moving plate, as shown in **Figure 19**, so the moving plate fits inside the channel of the resaw fence.

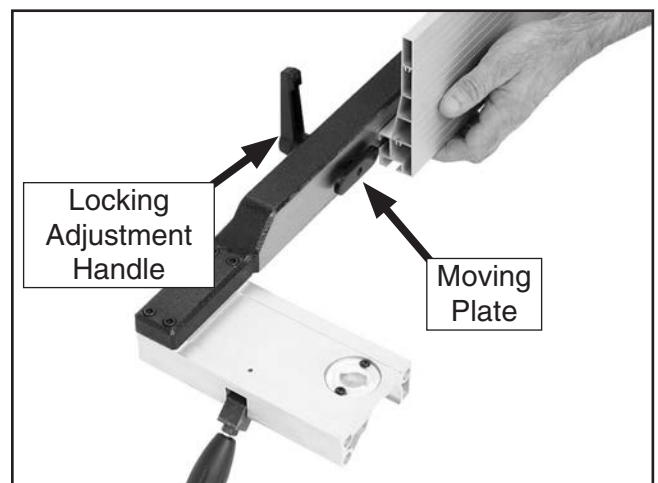


Figure 19. Attaching resaw fence to standard fence.



23. Pull the handle up and place the fence assembly on the fixed rail as shown in **Figure 20**.



Figure 20. Correctly installed fence.

24. Push the handle down to lock the fence assembly in place.
25. Position the resaw fence evenly on the table and use the locking adjustment handle to lock it in place.
26. Thread the M8-1.25 hex nut halfway onto the M8-1.25 x 80 hex bolt (this is the positive stop bolt).
27. Thread the positive stop bolt into the threaded hole on bandsaw body as shown in **Figure 21**.

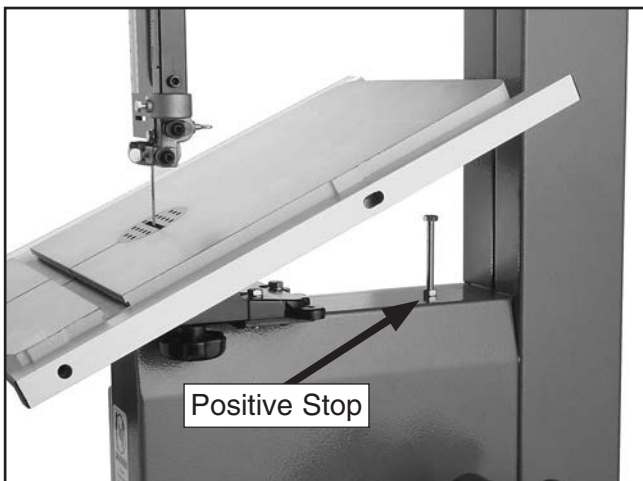


Figure 21. Installed positive stop bolt.

Dust Collection

⚠ CAUTION

DO NOT operate the Model G0457 without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port: 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit the 4" dust hose over the dust port, as shown in **Figure 22**, and secure in place with a hose clamp.
2. Tug the hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.



Figure 22. Dust hose attached to dust port.



Blade Tracking

The blade tracking is primarily affected by the tilt of the upper wheel, also known as "Center Tracking"; and the alignment of both wheels, also known as "Coplanar Tracking." (For Coplanar Tracking, see the **Wheel Alignment** instructions on **Page 49**.)

The wheels on the Model G0457 were aligned at the factory, so Center Tracking is the only adjustment that needs to be performed when the saw is new.

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Adjust the upper and lower guide bearings and support bearings as far away as possible from the blade.
3. Open the upper wheel cover.
4. Adjust blade tension until the mark on the blade tension scale matches the size of the installed blade.

CAUTION

The cast iron spokes may have sharp edges and the blade teeth may extend beyond the edge of the wheel, creating a laceration hazard. Be careful when turning the wheels by hand.

5. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 23** for an illustration of this concept.

—If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, then the bandsaw is already tracked properly and no further adjustments are needed at this time.

—If the blade does not ride in the center of the upper wheel and is not centered on the peak of the wheel crown, then continue with the following steps.

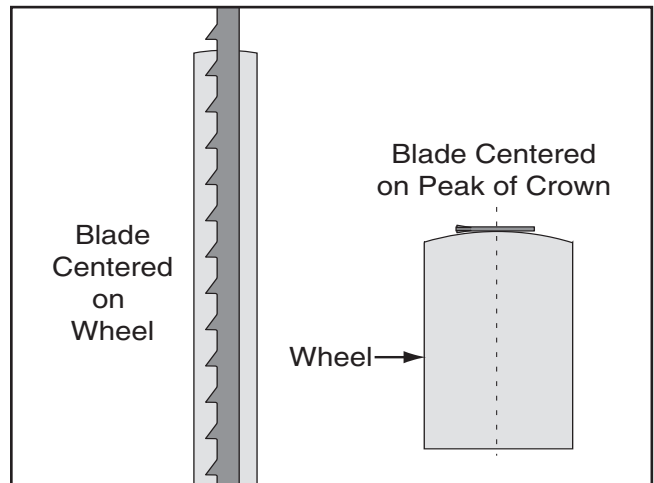


Figure 23. Center tracking profiles.

6. Loosen the tracking control lock knob (**Figure 24**) so that the tracking control knob will rotate for adjustments.

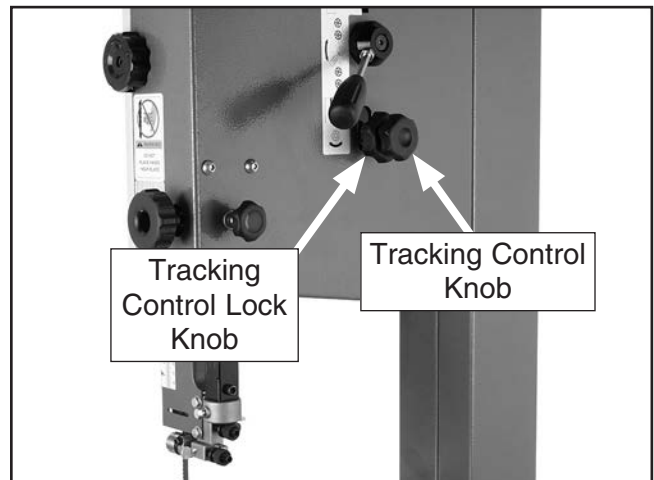


Figure 24. Location of tracking control knob.

7. Spin the upper wheel with one hand and rotate the tracking control knob with the other hand to make the blade ride in the center of the bandsaw wheel tire.
8. Tighten the tracking control lock knob and close the upper wheel cover.

For the best performance from your saw, regularly maintain the proper tracking of the blade.

NOTICE

Changes in the blade tension may change the blade tracking.



Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 43**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is set up properly, including **Blade Tracking** on **Page 20**.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Connect the machine to the power source.
4. Turn the machine **ON**.
5. Listen and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

—Strange or unusual noises must be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.
6. Turn the machine **OFF**.

Table Stop Calibration

The adjustable positive stop allows the table to be reset 90° to the blade after tilting to the right.

To set the positive stop:

1. DISCONNECT BANDSAW FROM POWER!
2. Adjust blade tension until the mark on the blade tension scale matches the size of the installed blade.
3. Loosen the hex nut that locks the positive stop bolt in place and loosen the table tilt hand knobs.
4. Raise the guide post and place a machinist's square on the table next to the side of the blade, as illustrated in **Figure 25**. Adjust the table square with the blade, then secure with the table tilt knobs.

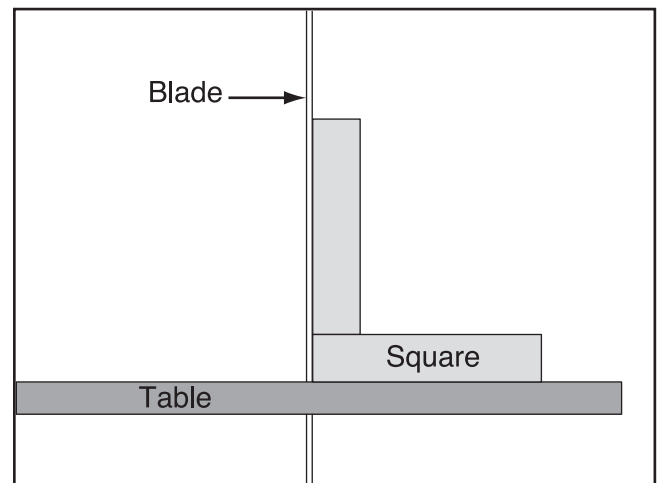


Figure 25. Squaring table to blade.

5. Adjust the positive stop bolt to the table.
6. Secure the positive stop bolt by tightening the hex nut against the trunnion bracket.
7. Check the adjustment for accuracy once you have tightened the hex nut.



Table Tilt Calibration

The pointer on the table tilt scale must be calibrated in order for the scale reading to be accurate.

To calibrate the pointer on the table tilt scale:

1. Make sure that the blade is tensioned and is tracking correctly, and that the table is 90° to the blade (see **Table Stop Calibration** on **Page** .
2. Loosen the screw on the pointer (**Figure 26**), but do not remove it.

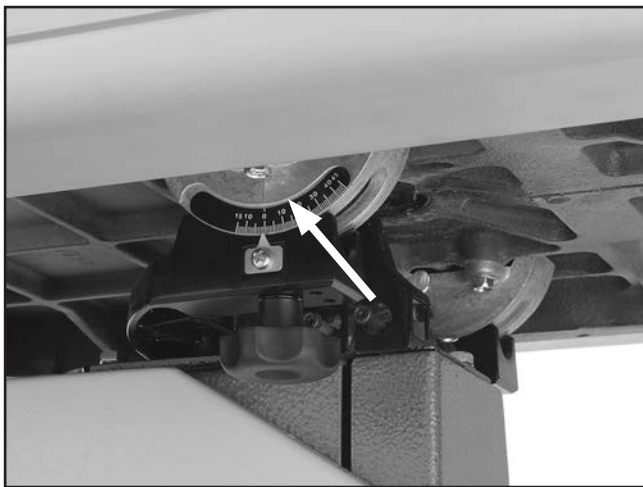


Figure 26. Table tilt scale.

3. Align the tip of the pointer with the 0° mark on the table tilt scale.
4. Tighten the screw on the pointer so that the pointer is locked in place.

Table Alignment

To ensure cutting accuracy when the table is first installed, the table should be aligned so that the miter slot is parallel to the bandsaw blade. This procedure works best with a 3/4" blade installed.

To align the table so the miter slot is parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Loosen the trunnion bolts that secure the trunnions to the table.
4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.

Note: Make sure the straightedge does not go across a tooth.

5. Use a fine ruler to gauge the distance between the straightedge and the miter slot. The distance you measure should be the same at both the front and the back of the table (see **Figure 27**).
6. Adjust the table as needed for proper alignment.
7. Tighten the trunnion bolts.

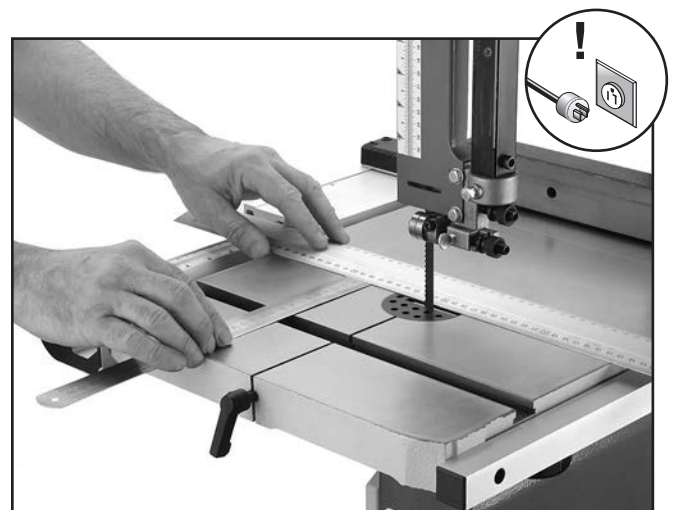


Figure 27. Measuring miter slot parallelism with the blade.



Fence Alignment

To ensure cutting accuracy when the fence is first installed, the fence should be aligned with the miter slot.

To align the fence parallel with the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and remount it next to the miter slot.
2. Loosen the four cap screws located on the top face of the fence (**Figure 28**).



Figure 28. Four fence cap screws.

3. Adjust the fence face parallel with the edge of the miter slot.
4. Tighten the four cap screws, being careful not to move the fence.

Miter Gauge

The miter gauge needs to be calibrated to the blade when it is first mounted in the miter slot.

To calibrate the miter gauge:

1. Place one edge of a machinist's square against the face of the miter gauge and the other side against the blade face, as shown in **Figure 29**.

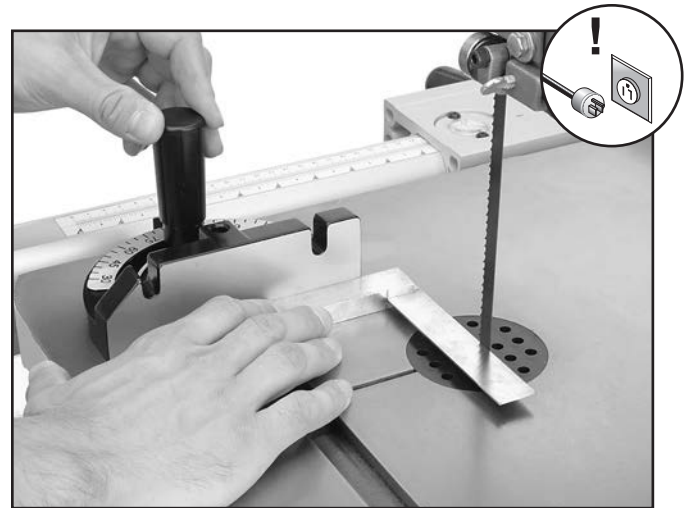


Figure 29. Squaring miter gauge to blade.

2. Loosen the lock knob on the miter gauge and adjust it flush with the edge of the square.
3. Tighten the lock knob, and verify the setting.

Note: Sometimes the tightening procedure can affect the adjustment.

4. Loosen the screw that secures the angle pointer and adjust the pointer to the 0° mark on the scale.
5. Retighten the screw that secures the angle pointer.



Blade Tensioning

A properly tensioned blade is essential for making accurate cuts and is a prerequisite for making many bandsaw adjustments. The blade tension scale shows the approximate tension, but the steps below will allow you to get the optimum tension for the installed blade.

To tension the bandsaw blade:

1. Make sure you have completed the **Test Run** procedure on **Page 21** and that the blade is tracking properly.
2. Raise the upper blade guide assembly as high as it will go, and adjust the upper and lower guide blocks as far away from the blade as possible.

Note: *This procedure will NOT work if the guide blocks have any contact with the blade.*

3. Adjust blade tension until the mark on the blade tension scale matches the size of the installed blade.

Note: *This scale can only be considered a general guide. Complete the following steps to accurately set blade tension.*

4. Turn the bandsaw **ON**.
5. Slowly release the tension one quarter of a turn at a time. When you see the bandsaw blade start to flutter, stop decreasing the tension.
6. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension another quarter turn.
7. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future.

Note: *Always de-tension the blade after use to increase blade life and reduce strain on the bandsaw components.*

NOTICE

After blade tension and tracking are set correctly, you **MUST** properly adjust the upper and lower support bearings and guide-block assemblies into position before cutting.

Adjusting Support Bearings

The support bearings are positioned behind the blade for support during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT BANDSAW FROM POWER!**
3. Familiarize yourself with the support bearing controls shown in **Figure 30**.

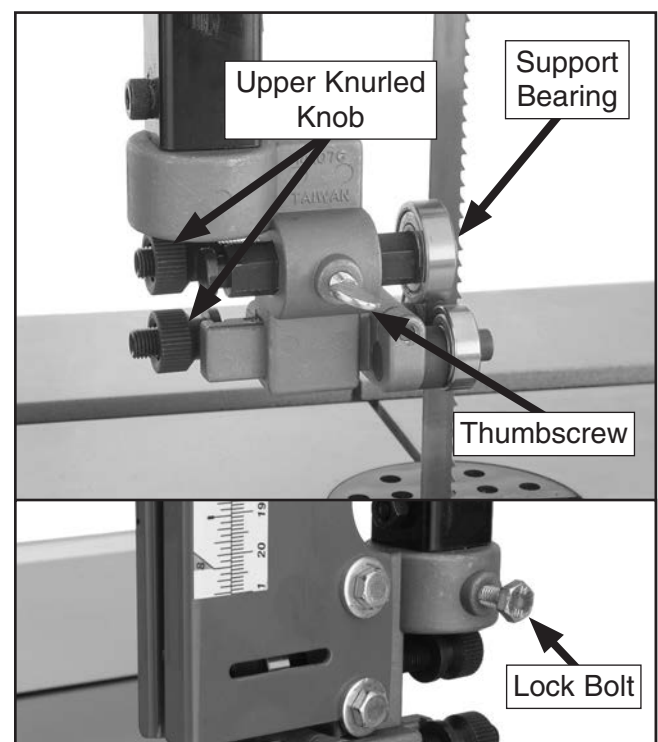


Figure 30. Support bearing controls.



4. Loosen the assembly lock bolt.
5. Rotate the blade guide assembly side-to-side, until the blade is perpendicular to the face of the support bearing as illustrated in **Figure 31**.

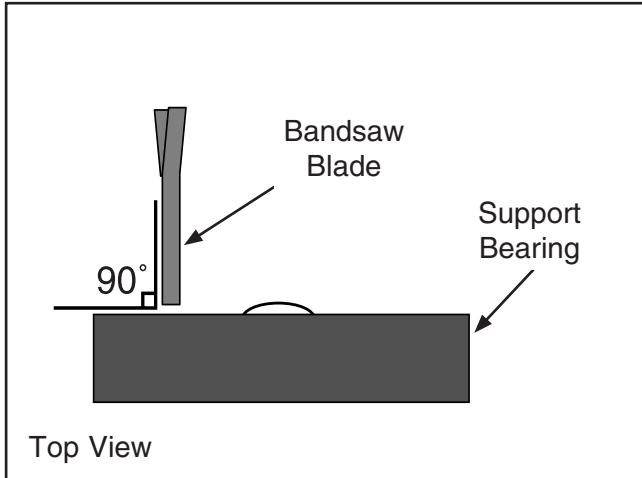


Figure 31. Blade should be perpendicular (90°) to the face of the support bearing.

6. Tighten the assembly lock bolt.
7. Loosen the thumbscrew on the support bearing adjustment shaft.
8. Place a 0.016" feeler gauge between the support bearing and the blade, and use the upper knurled knob to position the bearing 0.016" away from the back of the blade, as illustrated in **Figure 32**.

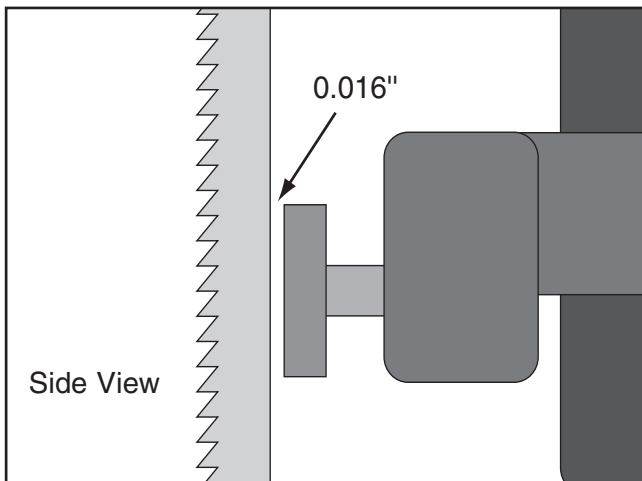


Figure 32. Blade should be aligned approximately 0.016" away from the bearing edge.

Note: For a quick gauge, fold a dollar bill in half twice (four thicknesses of a dollar bill is approximately 0.016") and place it between the support bearing and the blade as shown in **Figure 33**.

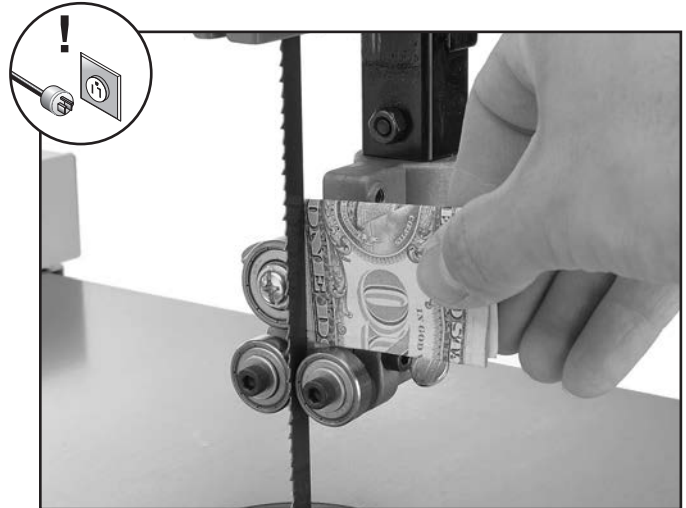


Figure 33. Dollar bill folded twice to make an approximate 0.016" gauge.

9. Tighten the thumbscrew to keep the support bearing locked in place.
10. Repeat **Steps 4–9** for the lower support bearings.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and blade guide bearings must be properly adjusted before cutting operations.



Blade Guide Adjustments

The blade guides consist of an upper and lower set of ball bearings that provide side-to-side support to help keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side.

To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Familiarize yourself with the blade guide controls shown in **Figure 34**.

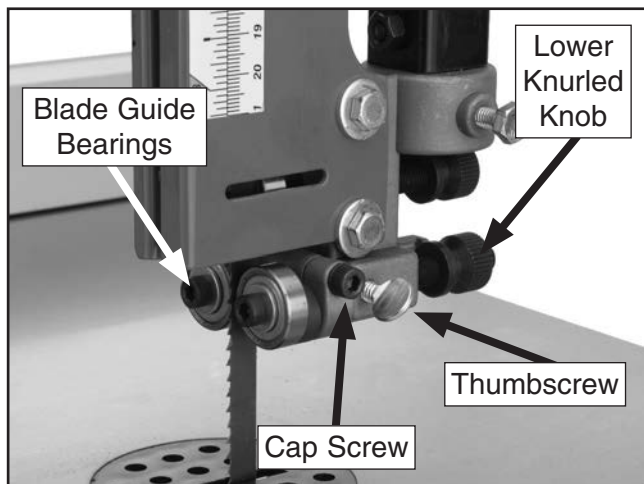


Figure 34. Blade guide controls.

4. Loosen the thumbscrew on the lateral adjustment rod.
5. Rotate the lower knurled knob to position the blade guides so the edges of the bearings are $\frac{1}{16}$ " behind the blade gullets, as illustrated in **Figure 35**.

Note: The $\frac{1}{16}$ " spacing is ideal, although with larger blades it may not be possible. In such cases, adjust the guide bearings as far forward as possible to the blade gullets, and still maintain the proper support bearing spacing adjustment.

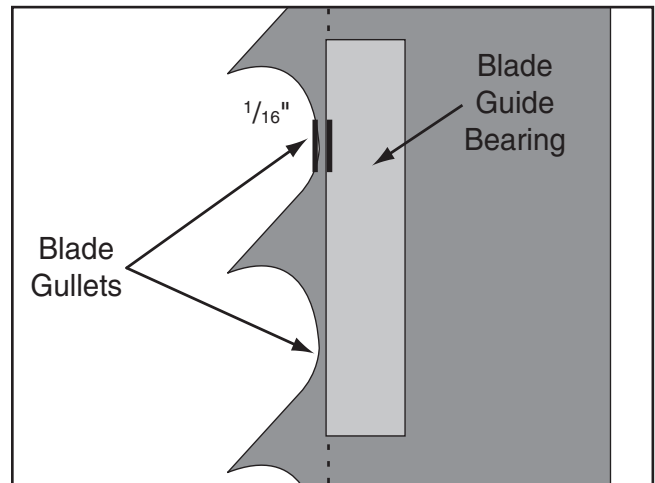


Figure 35. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide bearings when the blade is against the rear support bearing during the cut or the blade teeth will be ruined.

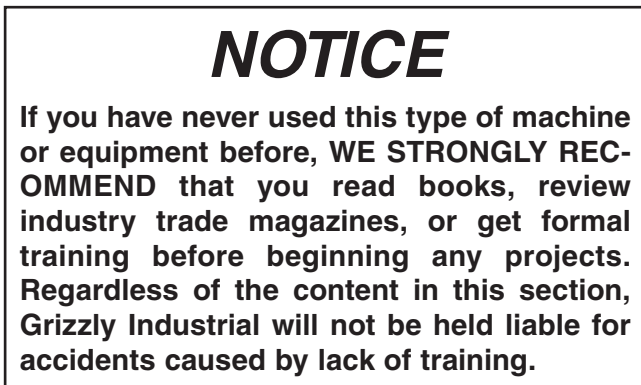
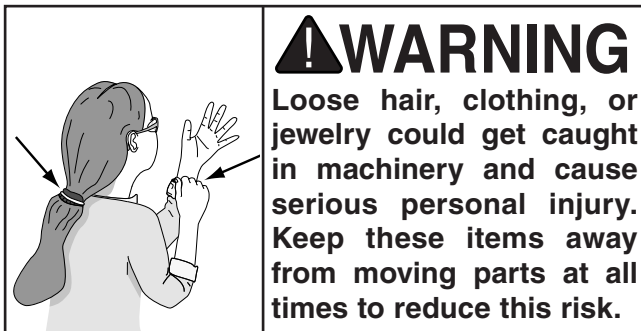
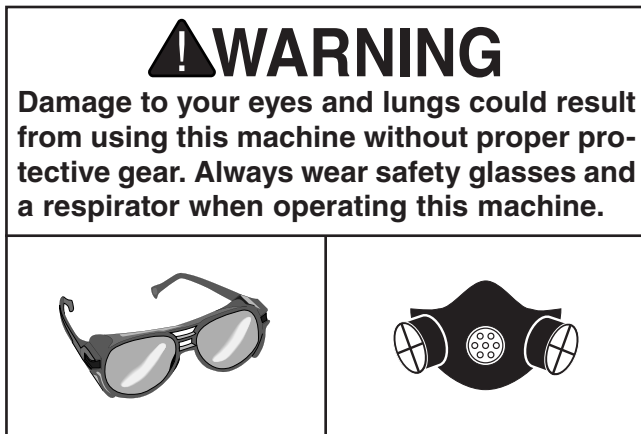
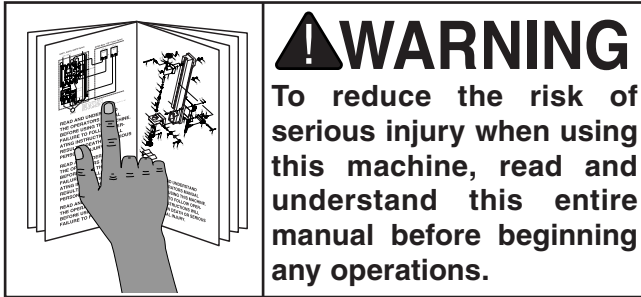
6. Tighten the thumbscrew on the lateral adjustment rod.
 7. Loosen the cap screws.
 8. With the 4mm hex wrench, rotate the center portion of the blade guide bearings to laterally position the bearings 0.004" away from the blade.
- Note:** 0.004" is approximately the thickness of a piece of paper.
9. Tighten the cap screw to lock the blade guide bearings in position.
 10. Repeat **Steps 4–9** for the lower guides.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide bearings must be properly adjusted before cutting operations.



SECTION 4: OPERATIONS



Basic Controls

Use the descriptions and figures below to become familiar with the basic controls of your machine.

Blade Tension Knob: Adjusts the tension on the blade.

Blade Tension Quick Release: Quickly tensions or releases the blade without losing its setting.

Blade tracking Adjustment Knob: Adjusts the blade tracking.

Guide Post Adjustment Knob: Raises and lowers the blade guide post.

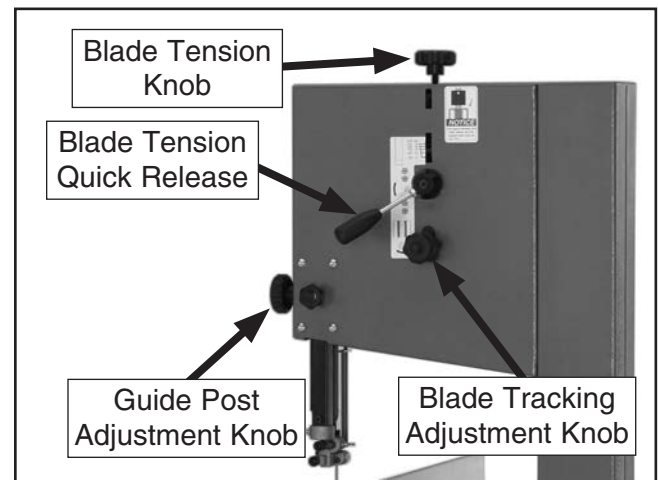


Figure 36. Basic controls (rear).



ON/OFF Switch: Starts and stops the blade motor.

Miter Gauge Lock Handle: Locks the miter gauge at the current setting.

Fence Lock Lever: Locks the fence at its current position.

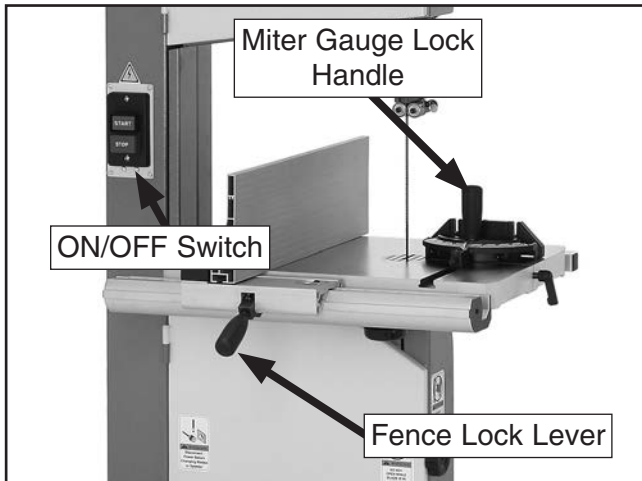


Figure 37. Basic controls (front).

Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing many different cutting functions, including:

Straight Cuts

- Miters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

A properly adjusted and tuned bandsaw can be safer to operate than most other saws and performs many functions with ease and accuracy.

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades as necessary and make adjustments periodically to keep the saw running in top condition.
- Use light and even pressure while cutting. Light contact with the blade will permit easier line following and prevent undue friction.
- Avoid trying to turn tight corners because this will twist the blade. Remember, you must saw around corners.
- Misuse of the saw or using incorrect techniques is unsafe and results in frustration and poor cuts. Remember—the blade does the cutting with the operator's guidance.



Workpiece Inspection

Some wood workpieces are not safe to cut or may require modification before they are safe to cut.

Before making cuts, get in the habit of inspecting all workpieces for the following:

- **Material Type:** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with this saw may lead to injury.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they cannot be removed, do NOT cut the workpiece.
- **Large/Loose Knots:** Loose knots can become dislodged during the cutting operation. Large knots can cause blade damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.
- **Wet or "Green" Stock:** Cutting wood with a moisture content over 20% causes unnecessary wear on the blade and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and can move unpredictably when being cut. DO NOT use workpieces with these characteristics!
- **Minor Warping:** Workpieces with slight cupping can be safely supported if the cupped side faces the table or fence. On the contrary, a workpiece supported on the bowed side will rock during a cut, leading to loss of control.

Table Tilt

The bandsaw table will tilt 8° left and 45° right to provide a wide range of cutting options. Most cutting operations are done at 90° and rarely will the table need to be tilted left. Remove the positive stop bolt to tilt the table to the left.

To tilt the table:

1. Loosen the two table trunnion hand knobs.
2. Position the table to the desired angle of tilt. Refer to the angle gauge on the front table trunnion for the tilting angle.
3. Retighten both table trunnion hand knobs.



Guide Post

The guide post, shown in **Figure 38**, connects the upper blade guide assembly to the bandsaw. The guide post allows the blade guide assembly to move up or down via a rack and pinion. In order to cut accurately, the blade guide assembly must be no more than 1" from the top of the workpiece at all times—this positioning provides the greatest support to the blade.

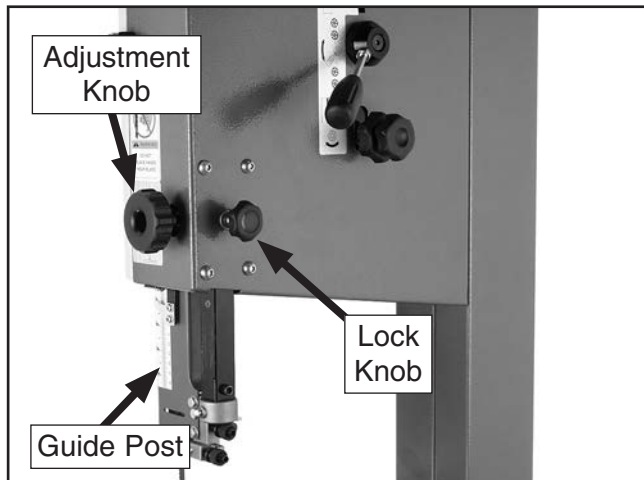


Figure 38. Guide post controls.

To adjust guide post:

1. Make sure that the blade tension, blade tracking, support bearing, and blade guides are adjusted correctly.
2. Loosen the guide post lock knob shown in **Figure 38**.
3. Raise/lower the guide post with the adjustment knob to within 1" from the top of the workpiece to the bottom of the blade guide assembly.
4. Lock the guide post in place with the lock knob.

Ripping

Ripping is the process of cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece.

To rip with the Model G0457:

1. Adjust the fence to match the width of the cut on your workpiece and lock the fence in place.
2. Make sure the bandsaw is properly set up and adjusted as described in **SECTION 3: SETUP**.
3. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 39** shows a typical ripping operation.

Note: *If you are cutting narrow pieces, use a push stick to protect your fingers.*



Figure 39. Ripping with a push stick.

⚠WARNING

NEVER place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may be pulled into the blade. **ALWAYS** use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!



Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

To crosscut with the Model G0457:

1. Mark the workpiece on the edge where you want to begin the cut.
2. Move the fence out of the way. Place the workpiece evenly against the miter gauge.
3. Line up the mark with the blade.
4. After all safety precautions have been met, turn the bandsaw **ON**. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 40** shows a typical crosscutting operation.



Figure 40. Crosscutting with miter gauge.

Resawing

Resawing (**Figure 41**) is the process of cutting a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw. Maximum cutting height for this bandsaw is 10".

The Model G0457 14" Industrial Bandsaw is capable of resawing, provided the saw is properly set up. Attempting to resaw too wide or too dense of a board may put excessive strain on the blade and cause breakage.

One of the most important considerations when resawing is blade selection. Generally, the wider blade, the better. In most applications, a hook or a skip tooth style will be desirable. Also, since most resawn lumber will be planed smooth, you should choose blades with fewer teeth-per-inch (from 3 to 6). While blades with fewer teeth-per-inch produce rougher cuts, these types of blades offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.

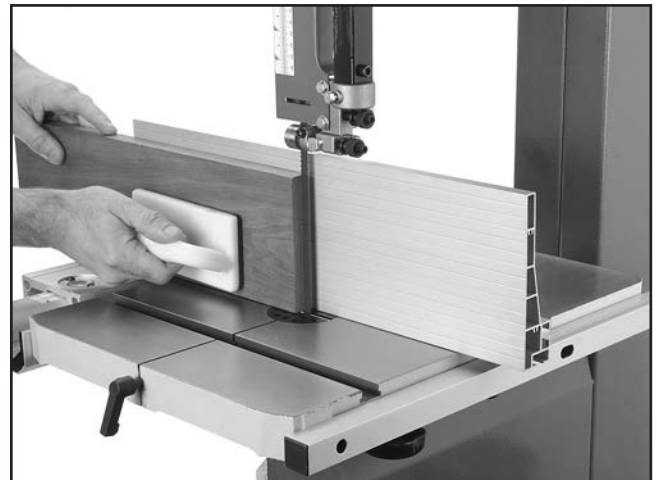


Figure 41. Resawing lumber.



To resaw a workpiece:

1. Verify that the bandsaw is set up properly and that the table is perpendicular to the blade.
2. Use the widest blade your bandsaw will accept.

Note: *The blade must also be sharp and clean.*
3. Use a fence to guide the workpiece.
4. Set your fence to the desired width of cut and lock it in place.
5. Support the ends of the board if necessary.
6. Turn the bandsaw **ON**.
7. Using push paddles and a push stick, keep pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece.

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without twisting. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use either a narrower blade or a blade with more TPI (teeth per inch), or make more relief cuts.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii each size of blade for the Model G0457.

Width	Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"



Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90°. Otherwise, any error will be compounded with each piece cut from the top to the bottom of the stack.

To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
 2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads!)
 3. On the face of the top piece, lay out the shape you intend to cut.
 4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade kerf to bind.
5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line as shown in **Figure 42**.

CAUTION

Cutting into brad nails that are used to secure the multiple pieces can cause the blade to break and may cause an injury to the operator. Be extremely careful of where you are cutting when performing this operation.

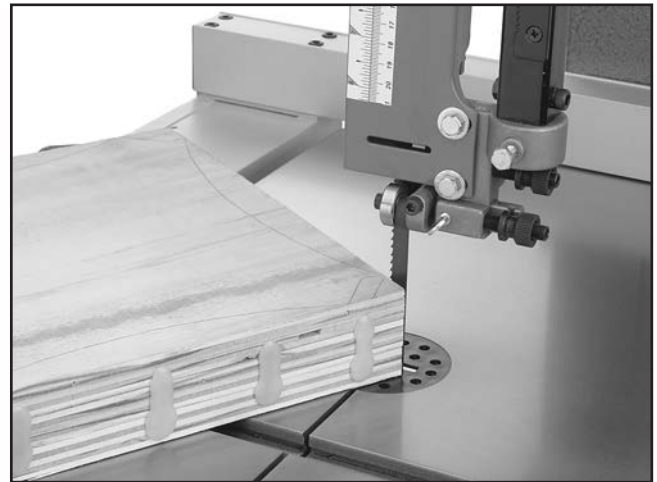


Figure 42. Cutting multiple pieces at once.



Blade Information

Selecting the right blade requires a knowledge of the various blade characteristics mentioned below, the type of material you plan to cut, and the type of cut you are going to perform.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0457 is designed for blades that are 106" long. Refer to the current Grizzly catalog for prices and ordering information.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

The Model G0457 can use blades from $\frac{1}{8}$ " to $\frac{3}{4}$ " in width. Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in **Figure 43** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

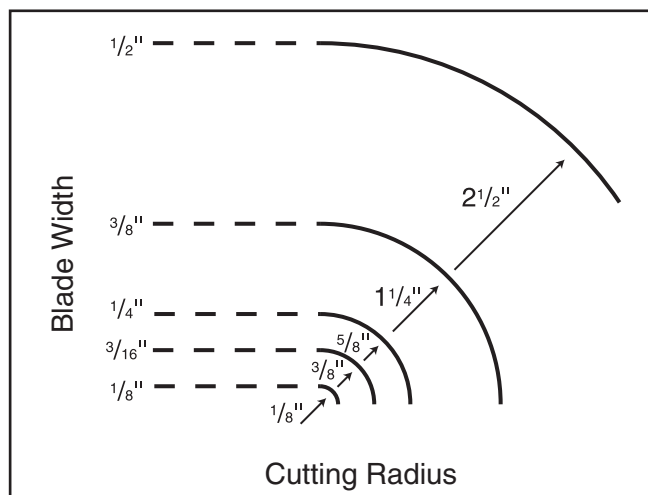


Figure 43. Blade width radii.

- **Straight Cutting:** Use the largest width blade that you own. The Model G0457 will accept blades up to $\frac{3}{4}$ " wide. Narrow blades can cut tight curves (a small radius) but are not very good at cutting straight lines because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines, but function poorly at cutting small curves because of their size.

Tooth Style

When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle—otherwise known as “Tooth Style.”

Figure 44 shows the three main categories of tooth style:

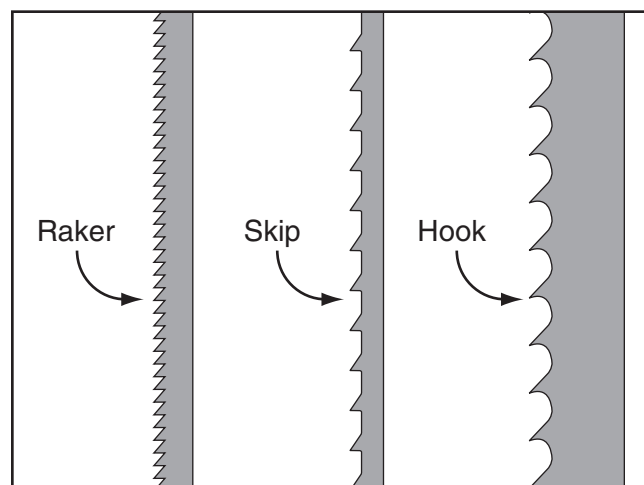


Figure 44. Raker, Skip & Hook tooth styles.

- **Raker:** This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but do not cut fast and generate more heat while cutting.
- **Skip:** This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.



- **Hook:** The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Usually measured as TPI (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

Blade Breakage

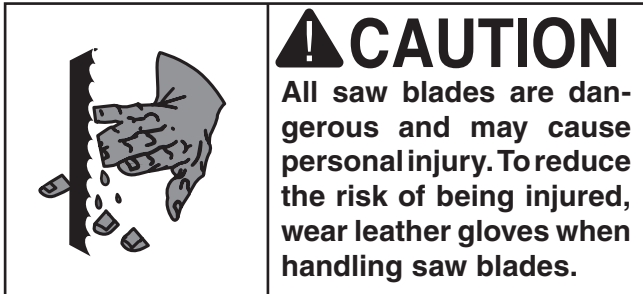
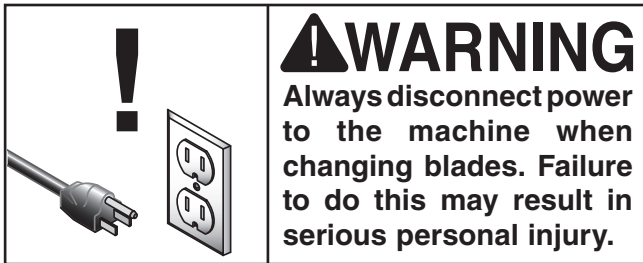
Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are:

- Aligning or adjusting the guides incorrectly.
- Forcing or twisting a wide blade around a curve of short radius.
- Feeding the workpiece into the blade too fast.
- Using a blade with dull teeth or the absence of sufficient set.
- Incorrect tension.
- Setting the top blade guide assembly set too high above the work piece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.



Blade Changes



To remove the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Release the blade tension by turning the blade tension quick release lever to the left.
3. Remove the table insert and the table pin. Adjust the upper and lower guide bearings as far away as possible from the blade.
4. Open the upper and lower wheel covers, and with gloved hands, slide the blade off both wheels.
5. Rotate the blade 90° and slide it through the slot in the table.

To replace the blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table.

Note: If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it right side-out.

2. Slip the blade through the guides, and mount it on the upper and lower wheels (**Figure 45**).

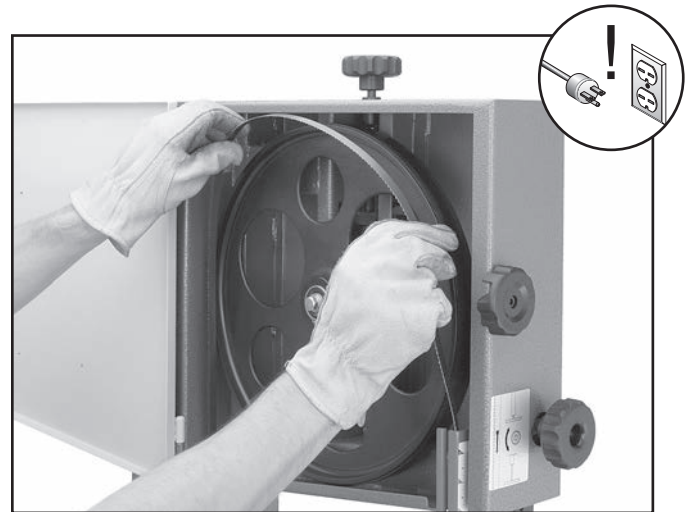


Figure 45. Placing blade on the wheels.

3. Tighten the blade tension quick release.
4. Apply tension to the blade by turning the tension control knob. Rotate the upper wheel slowly by hand as tension is applied to allow the blade to center itself on the wheel. Adjust tracking if needed.
5. Adjust tension as described **Page 24**.
6. Adjust the upper/lower guide bearings and the support bearings.
7. Close the wheel covers.
8. Replace the table insert and table pin, being sure not to use excessive force when inserting the table pin.



SECTION 5: ACCESSORIES

⚠️ WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

Replacement Blades

These 106" long replacement blades are milled for exact tooth set and are made with high quality tool steel.

MODEL	WIDTH	GAUGE	TPI	STYLE
G6638	1/8"	.035	14	Raker
G6639	1/8"	.035	18	Raker
G6640	3/16"	.035	4	Skip
G6641	3/16"	.035	10	Raker
G6642	3/16"	.035	14	Raker
G6643	1/4"	.035	4	Hook
G6644	1/4"	.035	6	Hook
G6645	1/4"	.035	10	Raker
G6646	1/4"	.035	14	Raker
G6647	1/4"	.035	18	Raker
G6648	3/8"	.035	4	Hook
G6649	3/8"	.035	6	Hook
G6650	3/8"	.035	10	Raker
G6651	3/8"	.035	14	Raker
G6652	1/2"	.035	3	Hook
G6653	1/2"	.035	4	Hook
G6654	1/2"	.035	6	Hook
G6655	1/2"	.035	10	Raker
G6656	1/2"	.035	14	Raker
G6657	3/4"	.035	3	Hook
G6658	3/4"	.035	6	Hook
G6659	3/4"	.035	10	Raker

Basic Eye Protection

- T20501—Face Shield Crown Protector 4"
- T20502—Face Shield Crown Protector 7"
- T20503—Face Shield Window
- T20451—"Kirova" Clear Safety Glasses
- T20452—"Kirova" Anti-Reflective S. Glasses
- H7194—Bifocal Safety Glasses 1.5
- H7195—Bifocal Safety Glasses 2.0
- H7196—Bifocal Safety Glasses 2.5



Figure 46. Assortment of basic eye protection.

- H4978—Deluxe Earmuffs - 27dB
 - H4979—Twin Cup Hearing Protector - 29dB
 - H4977—Work-Tunes Radio Earmuffs - 25dB
- Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



Figure 47. Our most popular earmuffs.



T20514—Small Half-Mask Respirator
T20515—Medium Half-Mask Respirator
T20516—Large Half-Mask Respirator
T20511—Pre-Filter P100
T20539—Cartridge Filter 2PK P100
T20541—Cartridge Filter 2PK P100 & O Vapor
 Wood and other types of dust can cause severe respiratory damage. If you work around dust every-day, a half-mask respirator can greatly reduce your risk. Compatible with safety glasses!



Figure 48. Half-mask respirator with disposable cartridge filters.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray



Figure 49. Recommended products for protecting unpainted cast iron/steel part on machinery.

H5408—Blade Tensioning Gauge
 The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.

The Blade Tensioning Gauge is made of lightweight, cast aluminum for optimum accuracy. Bright color coding makes it easy to use and easy to read. The Blade Tensioning Gauge comes in a handy metal box with instructions on the lid.



Figure 50. H5408 Blade Tensioning Gauge.

G7314—Heavy-Duty SHOP FOX® Mobile Base
 Make your machine mobile with this popular patented mobile base. The unique outrigger type supports increase stability and lower machine height. This heavy duty mobile base is rated for up to a 600 lb. capacity.



Figure 51. G7314 SHOP FOX® Mobile Base.



G1928—Bandsaw Handbook

This is the bandsaw bible. Covers step-by-step instructions for basic/advanced cutting techniques. Also includes advanced maintenance, service and troubleshooting procedures, as well as information on bandsaw history/design and blade metallurgy. 320 pages.

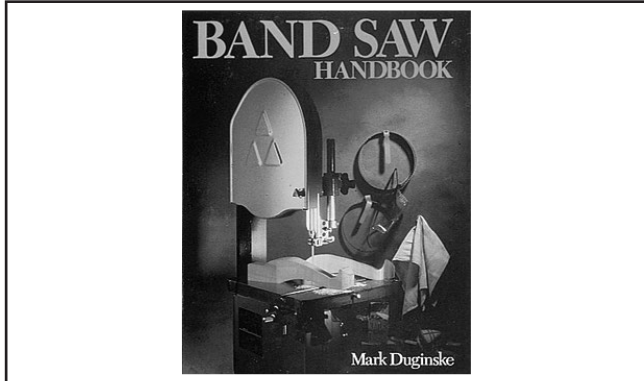


Figure 52. Bandsaw handbook.

G9256—6" Dial Caliper

G9257—8" Dial Caliper

G9258—12" Dial Caliper

These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!

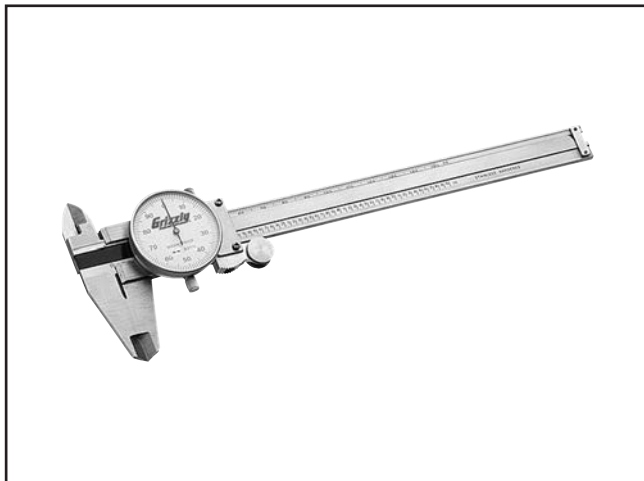


Figure 53. Grizzly® Dial Calipers.

G8983—Tilting Roller Stand

Adjusts from 26" to 44", 0°-45°. 150 lb. capacity.

G8984—Single Roller Stand

Adjusts from 26 5/8" to 45". 250 lb. capacity.

G8985—5 Roller Stand

Adjusts from 26" to 44 5/8". 250 lb. capacity.

These super heavy-duty roller stands feature convenient hand knobs for fast height adjustment.



Figure 54. SHOP FOX® Roller Stands.

G5683— Magnetic Base Light

Light up your work just where you need it. Flexible neck lamp features magnetic base that attaches with the twist of a switch so you can use it on every machine. 110V. Maximum 60 watt bulb.

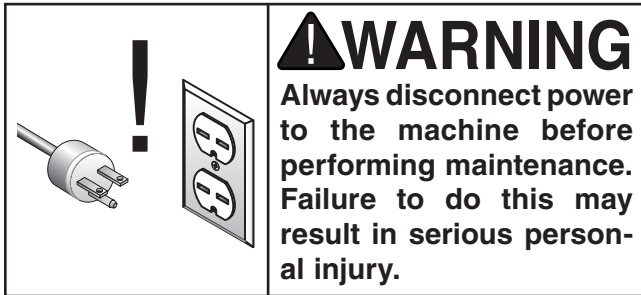


Figure 55. Magnetic Base Light.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check:

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning

Cleaning the Model G0457 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 37** for more details).

Lubrication

Sealed and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or bearing supply store.

For adjustment controls, an occasional “shot” of light oil is all that is necessary. Wipe off any sawdust with a clean cloth, towel or dry paint brush, and spray on the lubricant. Do not get oil on the pulleys or V-belt because it could cause belt deterioration and slipping.



Guide Post

1. DISCONNECT BANDSAW FROM POWER!
2. Open the upper wheel cover, then lower the guide post so the upper guide bearings almost touch the table.
3. Wipe the old grease off the rack (the long plate with teeth). The old grease will be contaminated with sawdust, so you want to remove as much of it as possible (**Figure 56**).

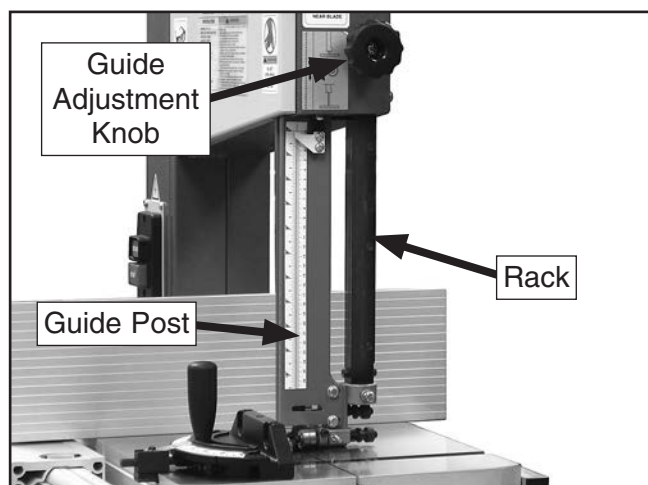


Figure 56. Guide post rack lubrication.

4. Use mineral spirits or degreaser to clean any remaining grease from the rack. Make sure to thoroughly wipe off the degreaser or mineral spirits after use so they won't contaminate the new grease.
5. Use a small, clean brush to apply NLGI#2 or equivalent automotive-grade multi-purpose grease to the rack. After applying, rotate the guide adjustment knob several times to distribute the grease.
6. Close the upper wheel cover, and re-adjust the guide post height as necessary.

Blade Tension Leadscrew

1. DISCONNECT BANDSAW FROM POWER!
2. Open the upper wheel cover, then wipe as much of the old grease off the blade tension leadscrew as possible. The old grease will be contaminated with sawdust, so you want to remove as much of it as possible (**Figure 36**).

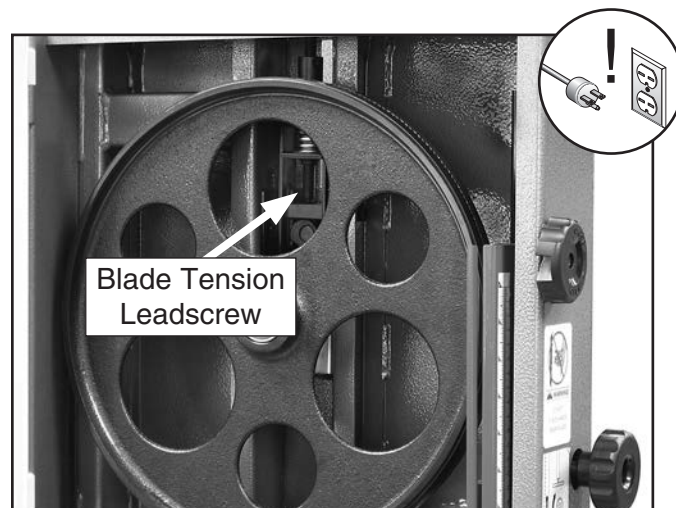


Figure 57. Blade tension leadscrew.

3. Use mineral spirits or degreaser to clean any remaining grease from the leadscrew. Make sure to thoroughly wipe off the degreaser or mineral spirits after use so they will not contaminate the new grease.
4. Use a small, clean brush to apply NLGI#2 or equivalent automotive-grade multi-purpose grease to the leadscrew. After applying, rotate the blade tension knob through its full range of motion to distribute the grease.
5. Close the upper wheel cover, and re-adjust the blade and belt tension as necessary.



Table Trunnions

1. DISCONNECT BANDSAW FROM POWER!
2. Wipe the old grease off the bearing surfaces of the table trunnions. Start with the outward side of the table trunnions (**Figure 58**) when the table is at 0°, then tilt the table to 45° and wipe off the inward side. The old grease will be contaminated with sawdust, so you want to remove as much of it as you can.

Note: For easiest access to the trunnions and the best cleaning results, consider removing the table during this procedure.

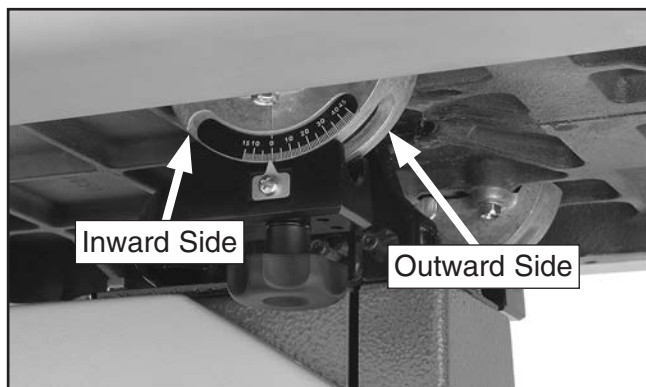


Figure 58. Sides of table trunnions to grease.

3. Use mineral spirits or degreaser to clean any remaining grease from the trunnions. Make sure to thoroughly wipe off the degreaser or mineral spirits after use so they won't contaminate the new grease.
4. Use a small, clean brush to apply NLGI#2 or equivalent automotive-grade multi-purpose grease to the trunnion bearing surfaces. After applying, tilt the table back and forth from 0° to 45° to distribute the grease.

Redressing Rubber Tires

As the bandsaw ages, the rubber tires on the wheels may need to be redressed if they harden or glaze over. Redressing the rubber tires improves blade tracking and reduces vibration/blade lead.

If the rubber tires become too worn, then blade tracking will become extremely difficult. At that point, redressing will no longer be effective and the rubber tires must be replaced.

To redress the rubber tires:

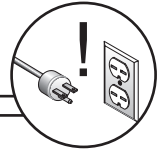
1. DISCONNECT BANDSAW FROM POWER!
2. Put on heavy leather gloves.
3. Remove the blade.
4. Clean any built-up sawdust from the rubber tires.
5. Hold 100 grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



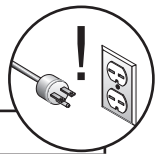
Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Plug/receptacle is at fault or wired incorrectly. 2. Motor connection wired incorrectly. 3. Power supply is at fault/switched OFF. 4. Motor ON/OFF switch is at fault. 5. Wiring is open/has high resistance. 6. Start capacitor is at fault. 7. Motor is at fault. 	<ol style="list-style-type: none"> 1. Test for good contact or correct the wiring. 2. Correct motor wiring connections (Page 51). 3. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 4. Replace faulty ON/OFF switch. 5. Check for broken wires or corroded/disconnected connections, and repair/replace as necessary. 6. Test/replace if faulty. 7. Repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Wrong workpiece material (wood). 2. Processing speed too fast for task. 3. Low power supply voltage. 4. Run capacitor is at fault. 5. V-belt slipping. 6. Plug/receptacle is at fault. 7. Motor connection is wired incorrectly. 8. Blade is slipping on wheels. 9. Motor bearings are at fault. 10. Motor has overheated. 11. Motor is at fault. 	<ol style="list-style-type: none"> 1. Use wood with correct moisture content, without glues, and little pitch/resins. 2. Decrease processing speed. See Basic Cutting Tips on Page 28. 3. Ensure all hot lines have correct voltage on all legs. 4. Repair/replace. 5. Replace bad V-belt, align pulleys, and re-tension (Page 46). 6. Test for good contacts and correct wiring. 7. Correct motor wiring connections (Page 51). 8. Adjust blade tracking (Page 20) and tension (Page 24) to factory specifications. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 10. Clean off motor, let cool, and reduce workload. 11. Repair/replace.



Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation when running.	<ol style="list-style-type: none"> 1. Motor or component is loose. 2. V-belt worn or loose. 3. Motor fan is rubbing on fan cover. 4. Pulley is loose. 5. Machine is incorrectly mounted or sits unevenly on floor. 6. Motor bearings are at fault. 7. Blade weld is at fault or teeth are broken. 8. Worn arbor bearings. 9. Wheels not coplanar/aligned correctly. 10. Tires incorrectly installed. 11. Bent or worn out blade. 12. Wheels out of balance. 	<ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Inspect/replace belt (Page 46). 3. Replace dented fan cover and loose/damaged fan. 4. Realign/replace shaft, pulley, set screw, and key as required. 5. Adjust the feet on the bottom of the stand; relocate machine. 6. Test by rotating shaft — rotational grinding/loose shaft requires bearing replacement. 7. Replace blade (Page 36). 8. Check/replace arbor bearings. 9. Adjust wheel alignment to coplaner (Page 49). 10. Re-install tires. 11. Replace blade (Page 36). 12. Replace wheels.

Cutting Operations



Symptom	Possible Cause	Possible Solution
Machine slows when operating.	<ol style="list-style-type: none"> 1. Applying too much pressure to workpiece. 2. Blade is dull. 	<ol style="list-style-type: none"> 1. Feed workpiece slower. See Basic Cutting Tips on Page 28. 2. Replace blade (Page 36).
Ticking sound when the saw is running.	<ol style="list-style-type: none"> 1. Blade weld contacting support bearing. 2. Blade weld may be failing. 	<ol style="list-style-type: none"> 1. Use file or stone to smooth and round the back of the blade. 2. Inspect and replace blade if necessary (Page 36).
Blade contacting table insert.	<ol style="list-style-type: none"> 1. Excessive side pressure when cutting. 2. Table improperly adjusted. 	<ol style="list-style-type: none"> 1. Reduce side pressure. 2. Adjust table (Page 22).
Vibration when cutting.	<ol style="list-style-type: none"> 1. Loose or damaged blade. 	<ol style="list-style-type: none"> 1. Tighten or replace blade. See Page 24 or 36.
Burn marks on the edge of the cut.	<ol style="list-style-type: none"> 1. Too much side pressure when feeding workpiece. 2. Blade too wide for size of radius being cut. 	<ol style="list-style-type: none"> 1. Feed workpiece straight into the blade. See Basic Cutting Tips on Page 28. 2. Install a smaller width blade/increase blade tension. See Page 24 or 36.
Rough or poor quality cuts.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 	<ol style="list-style-type: none"> 1. Reduce feed rate. See Basic Cutting Tips on Page 28.
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. 	<ol style="list-style-type: none"> 1. Clean out dust port. 2. Three options: <ul style="list-style-type: none"> —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a stronger dust collector.
Blade wanders or won't follow line of cut.	<ol style="list-style-type: none"> 1. Blade lead. 	<ol style="list-style-type: none"> 1. Refer to Blade Lead on Page 47.



Checking V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension. The belt should be checked for cracks, fraying, and wear. Belt tension should be checked at least every 3 months—more often if the bandsaw is used daily.

To check the V-belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Push the center of the V-belt. Note the amount of deflection.
 - If deflection is more than $\frac{3}{8}$ ", tighten the V-belt.
4. Note the condition of the V-belt.
 - If the V-belt is cracked, frayed, or glazed; it should be replaced as soon as convenient.

Tensioning V-Belt

Tools Needed:	Qty
Hex Wrench 6mm.....	1

To tension the V-belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Loosen the motor mount screws shown in **Figure 59**.

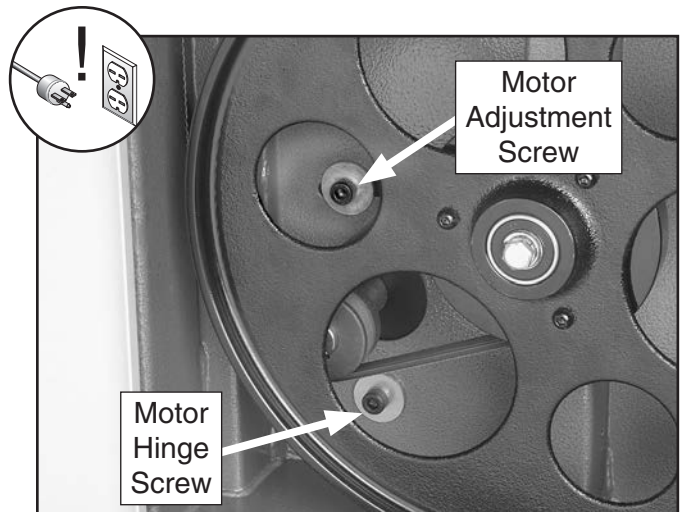


Figure 59. Motor mount screws.

4. Move the body of the motor, sliding the adjustment screw to the left-hand side (facing bandsaw front) of the adjustment slot.
5. Hold the motor in position with one hand and tighten the motor adjustment screw with the other hand.
6. Push the center of the V-belt.
 - If deflection is approximately $\frac{3}{8}$ " with moderate pressure from your thumb or finger (**Figure 60**), then the tension is correct.
 - If the deflection is more than $\frac{3}{8}$ ", repeat **Steps 3-6**.

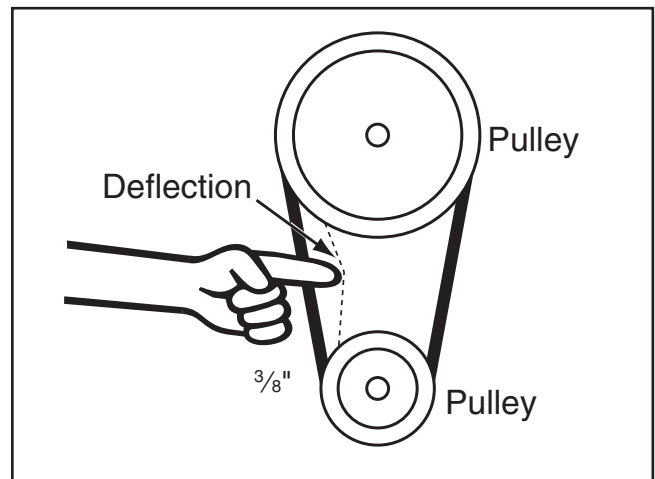


Figure 60. Testing belt tension.

7. When the V-belt tension is correct, tighten the motor hinge screw and close the lower wheel cover.



Replacing V-Belt

Tools Needed:	QTY
Hex Wrench 6mm.....	1
Wrench 13mm	1

To replace the V-belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open both wheel covers, and remove the blade.
3. Loosen the motor screws shown in **Figure 59**.
4. Unthread the wheel mount bolt shown in **Figure 61** and slide the lower wheel off of the bearing shaft.

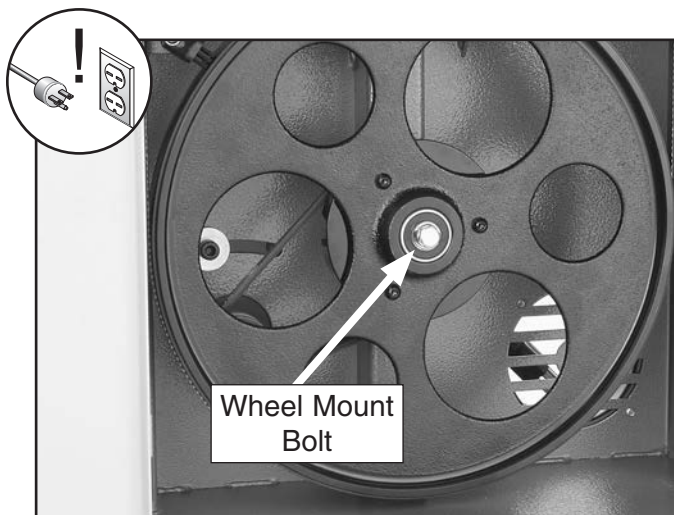


Figure 61. Wheel mount bolt.

5. Move the body of the motor so that the motor adjustment screw slides to the right-hand side (facing bandsaw front) of the adjustment slot and pull the V-belt off of the motor pulley.
6. Slip the old V-belt off of the wheel pulley and install the new V-belt in its place.
7. Install the lower wheel back onto the bearing shaft and replace/tighten the wheel mount bolt.
8. Position the V-belt over the motor pulley. Move the body of the motor so that the motor adjustment screw slides to the left-hand side (facing bandsaw front) of the adjustment slot.
9. Hold the motor in position with one hand and tighten the motor adjustment screw with the other hand.
10. Check the V-belt tension and adjust if necessary as described in the **Tensioning V-Belt** instructions on **Page 45**.
11. When the V-belt tension is correct, tighten the motor hinge bolt, replace the blade, then close both wheel covers.



Shimming Table

To ensure accuracy when cutting stacked workpieces, the table should be 90° to the back of the blade as shown in **Figure 62**. If the table is not perpendicular to the back of the blade, the table needs to be shimmed.

Shims can be made of any durable object that can be sandwiched between the table and the trunnions. We recommend using shim washers or shim stock because of the wide range of available thicknesses. These items can be purchased at your local hardware store.

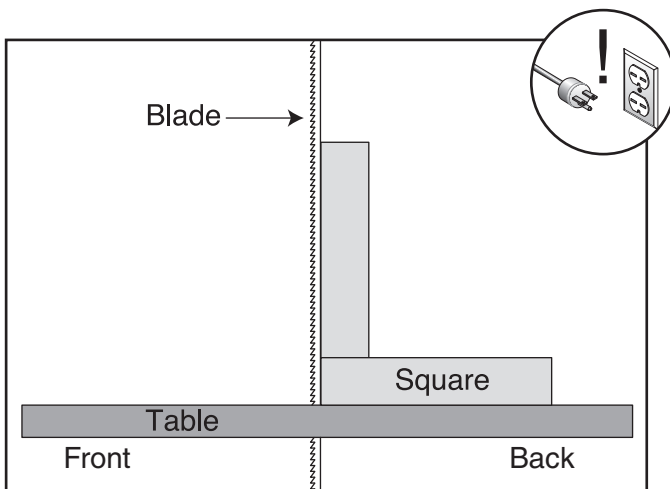


Figure 62. Squaring table to blade back.

To shim the table:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT BANDSAW FROM POWER!**
3. Loosen the table mounting bolts that secure the table to the trunnion.
4. Place shims between the table and the trunnion to position the table in the desired direction.
5. Follow the **Aligning Table** instructions on **Page 22** to complete this procedure.

Blade Lead

Bandsaw blades sometimes wander off the cut line when sawing, as shown in **Figure 63**. This is called blade lead. Blade lead is commonly caused by too fast of a feed rate, a dull or abused blade, or improper tension. If your blade is sharp/undamaged and you still have blade lead, perform the following instructions.



Figure 63. Blade leading away from line of cut.

Correct blade lead

1. Use less pressure when feeding the workpiece through the cut.
2. Check that the miter slot or fence is parallel to the blade line, and correct if necessary.
3. Check for proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by skewing the fence or adjusting the table.

Skewing your fence

1. Cut a piece of scrap wood approximately $\frac{3}{4}$ " thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.
2. Cut halfway through the board on the line by pushing it into the blade. Turn the bandsaw **OFF** and wait for the blade to stop.



3. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.
4. Loosen the four cap screws on top of the fence.
5. Skew the fence so it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.
6. While maintaining the skew, tighten the cap screws.

NOTICE

Lead adjustments will change when new blades are mounted on the saw.

Shifting Table

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Cut halfway through the board on the line by pushing it into the blade.
3. Turn the bandsaw **OFF** and wait for the blade to stop.
4. Loosen the table mounting bolts, shift the table to compensate for the blade lead, then retighten the bolts.
5. Repeat **Steps 1–4** until the blade cuts straight.

NOTICE

If the table is shifted, the fence will need to be re-aligned, and the blade guides and blade support will need to be re-adjusted.



Wheel Alignment

Components and Hardware Needed:	Qty
45 ¹ / ₂ " Long 2x4	1

Tools Needed:

Wrench 13mm	1
Tape Measure.....	1
Coplanarity Gauge (see Figure 64).....	1

Wheel alignment is one of the most critical factors for optimal performance from your bandsaw.

Heat, vibration, wandering, blade wear, tire wear and overall bandsaw wear are considerably decreased when the wheels are properly aligned or “coplanar.”

Coplanar wheels automatically track the blade by balancing it on the crown of the wheel. This is known as coplanar tracking.

To check if your wheels are coplanar:

1. Make the "Coplanarity Gauge" shown in **Figure 64**.

Note: For best results, straighten the 2x4 with a jointer before cutting.

2. Remove the fence and table, then open both wheel covers.
3. Make sure the guide blocks and rear support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.
4. Place your coplanarity gauge up against both wheels in the positions shown in **Figure 65**.
5. The adjustment hub allows you to move the lower wheel in the desired direction. Turning all the bolts clockwise in equal amounts pushes the wheel forward. Turning all the bolts counterclockwise brings the wheel backward, closer to the adjustment hub. Used individually, each bolt can control the direction that the wheel tilts.

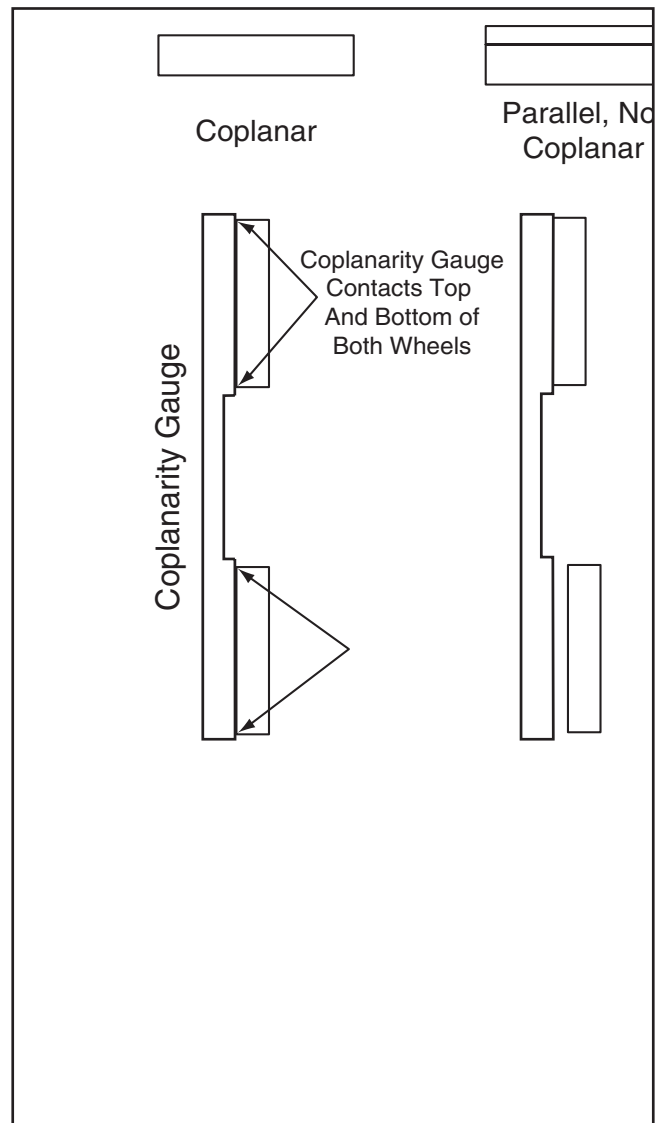


Figure 64. Dimensions of coplanarity gauge.

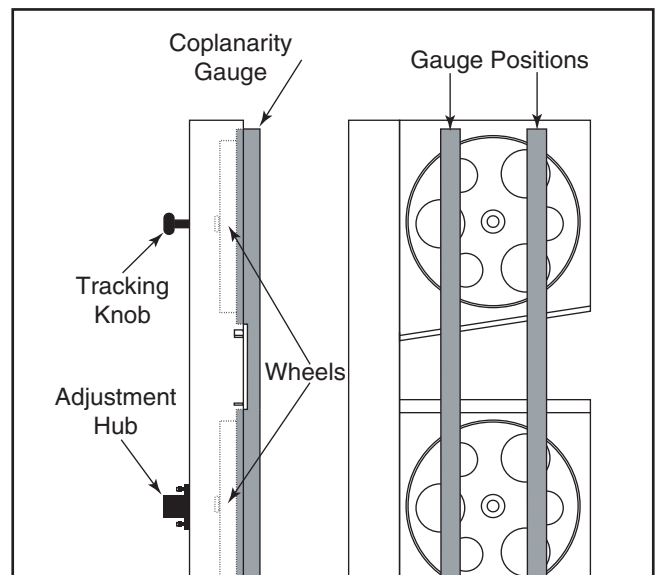


Figure 65. Checking for coplanarity.



6. Adjust the tracking knob to get both wheels parallel. If the wheels won't go parallel to each other, then move the lower wheel at the adjustment hub so they line up.
7. If the wheels will go parallel but not coplanar, then move the lower wheel at the adjustment hub (**Figure 66**) as necessary.
8. **Figure 67** shows the positions of the wheels when coplanar. When your wheels are coplanar, readjust the guide blocks and rear support bearings, and replace the wheel covers.

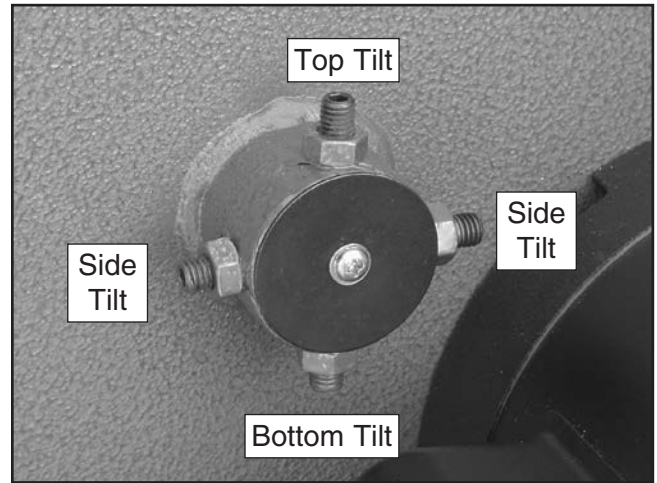


Figure 66. Lower wheel adjustment control.

Note: *The blade may track slightly **OFF** center when the wheels are coplanar. This is natural because the blade will be balanced **ON** the crown of the tire, rather than just in the center of the tire. This will be more noticeable with larger blades.*

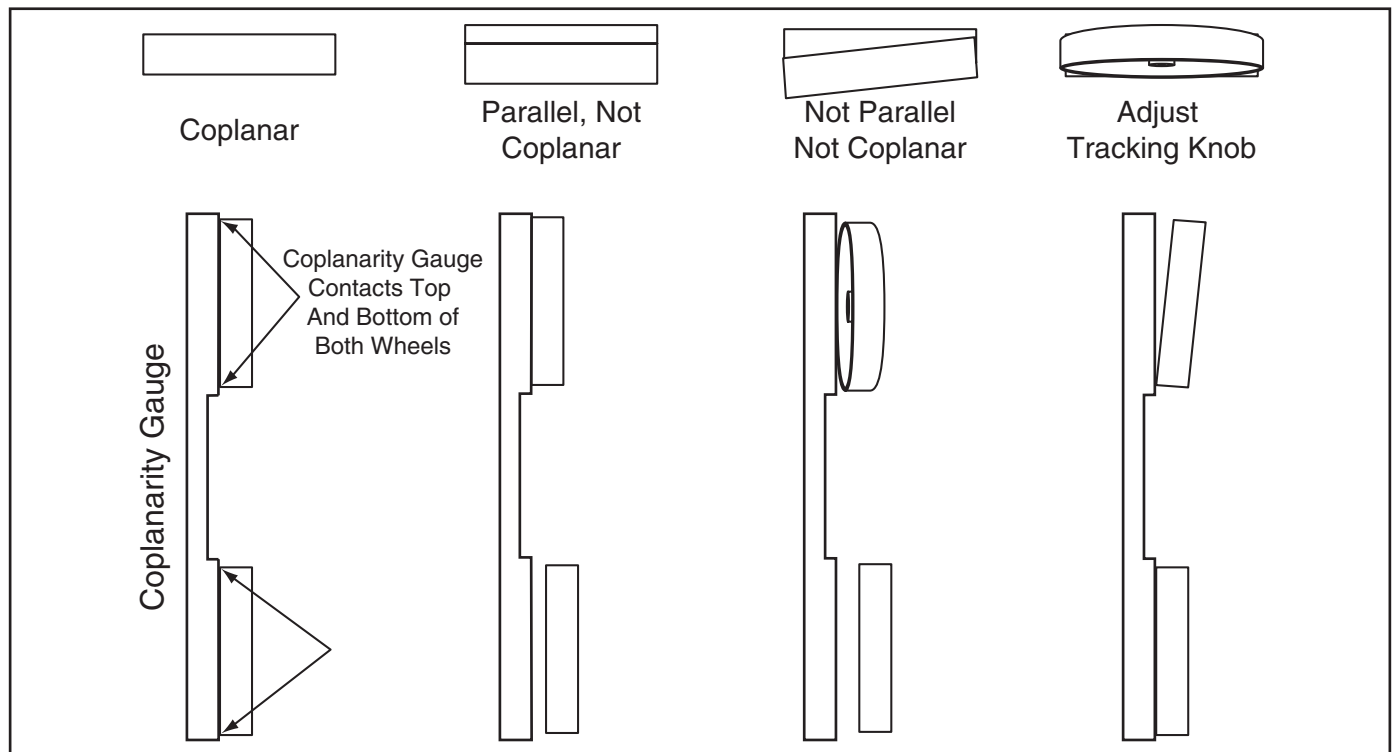


Figure 67. Coplanarity diagram.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.
















CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



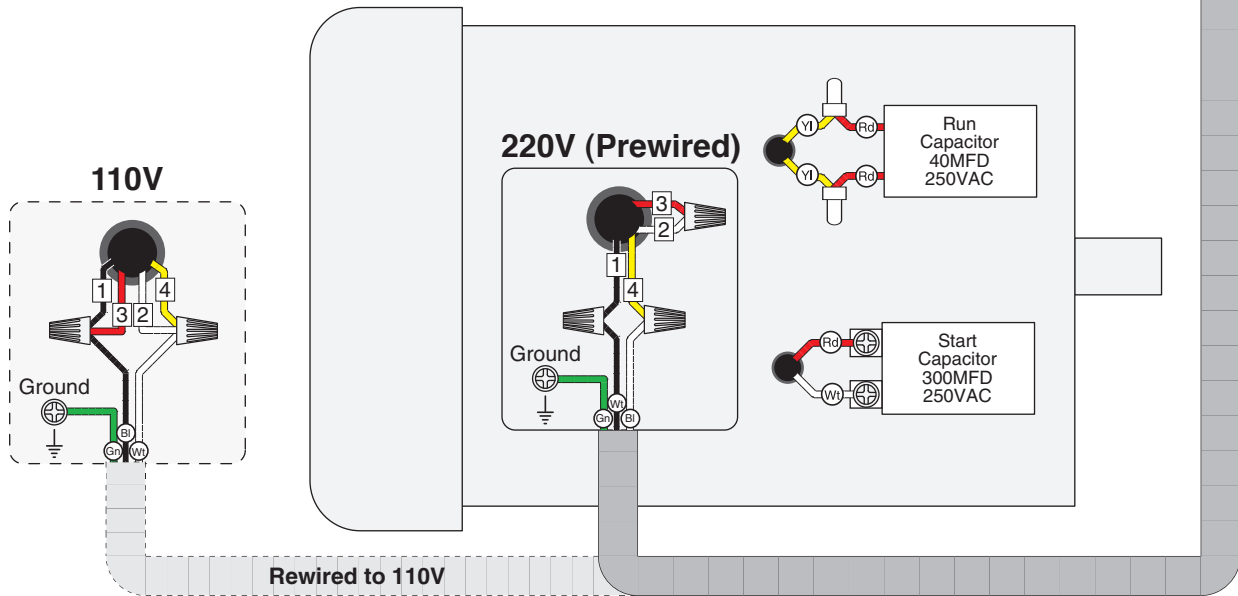
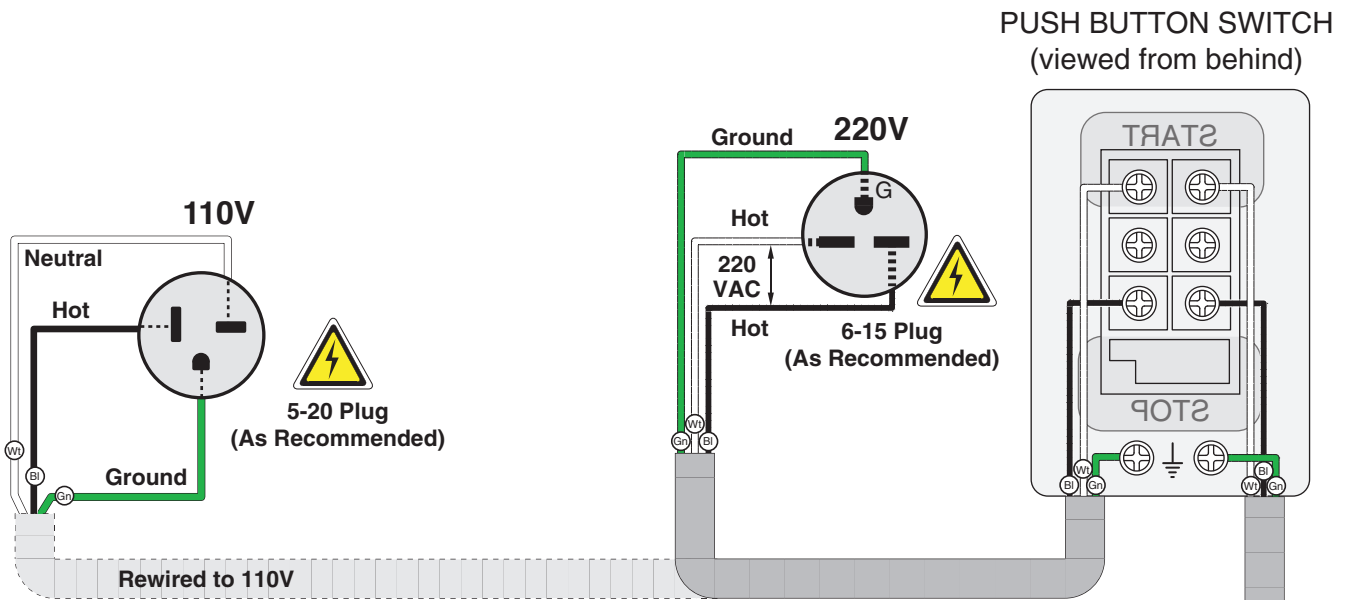


Figure 68. Motor wiring.

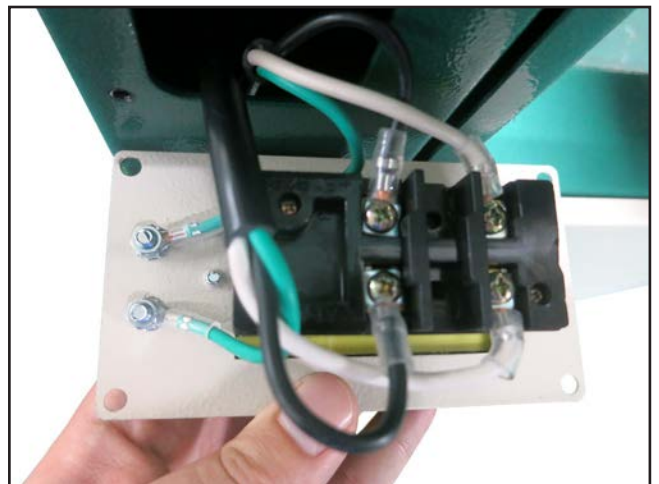
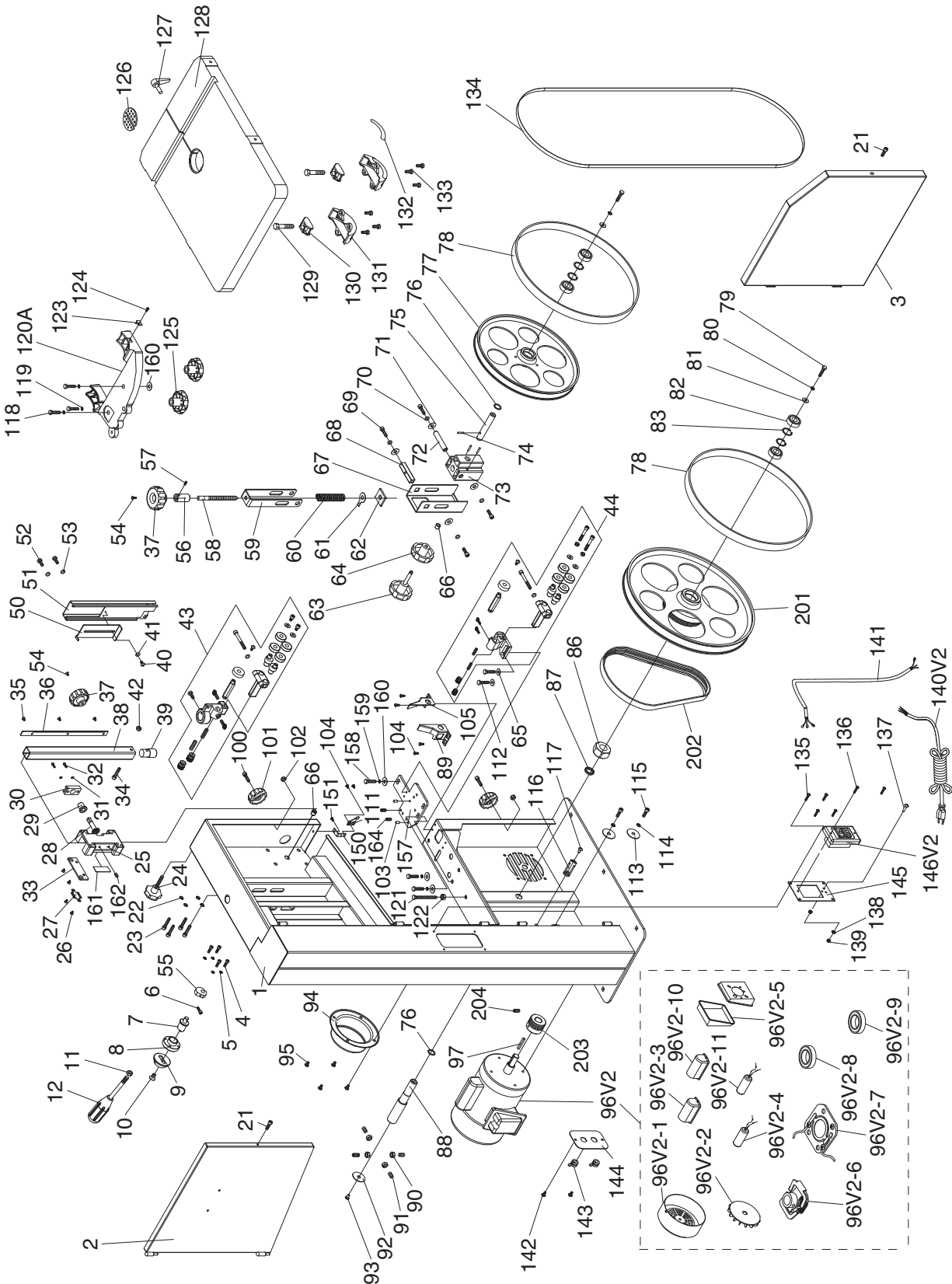


Figure 69. Push button switch wiring.



SECTION 9: PARTS

Main



Main Parts List

REF	PART #	DESCRIPTION
1	P0457001	BODY
2	P0457002	UPPER WHEEL DOOR
3	P0457003	LOWER WHEEL DOOR
4	PCAP04M	CAP SCREW M6-1 X 10
5	PLW03M	LOCK WASHER 6MM
6	PCAP33M	CAP SCREW M5-.8 X 12
7	P0457007	BIAS SHAFT
8	P0457008	BIAS SHAFT CLAMP SEAT
9	P0457009	TENSION ADJUSTMENT HUB
10	PCAP14M	CAP SCREW M8-1.25 X 20
11	PN03M	HEX NUT M8-1.25
12	P0457012	TENSION HANDLE
21	PCAP04M	CAP SCREW M6-1 X 10
22	PLW04M	LOCK WASHER 8MM
23	PCAP14M	CAP SCREW M8-1.25 X 20
24	P0457024	LOCK KNOB M8-1.25 X 20
25	P0457025	UPPER GUIDE POST SUPPORT
26	PFH27M	FLAT HD SCR M4-.7 X 6
27	P0457027	SPRING TENSIONER
28	P0457028	ADJUSTMENT GEAR SHAFT
29	P0457029	BUSHING
30	P0457030	GEAR SHAFT BRACKET
31	PLW03M	LOCK WASHER 6MM
32	PCAP04M	CAP SCREW M6-1 X 10
33	P0457033	COVER PLATE
34	PCAP48M	CAP SCREW M6-1 X 35
35	PFH27M	FLAT HD SCR M4-.7 X 6
36	P0457036	RACK
37	P0457037	HAND KNOB M10-1.5
38	P0457038	GUIDE POST
39	P0457039	CHANGE SHAFT
40	PS14M	PHLP HD SCR M6-1 X 12
41	P0457041	WASHER 6MM PLASTIC
42	PLN03M	LOCK NUT M6-1
43	P0457043	UPPER BLADE GUIDE ASSEMBLY
44	P0457044	LOWER BLADE GUIDE ASSEMBLY
50	P0457050	SLIDING BLADE GUARD
51	P0457051	BLADE GUARD
52	PB05M	HEX BOLT M6-1 X 8
53	PW03M	FLAT WASHER 6MM
54	PFS06M	FLANGE SCREW M6-1 X 8
55	P0457055	CAM
56	P0457056	LOCK COLLAR
57	PSS07M	SET SCREW M5-.8 X 5
58	P0457058	TENSION ADJUSTMENT SCREW
59	P0457059	ADJUSTMENT SCREW BRACKET
60	P0457060	COMPRESSION SPRING
61	P0457061	TENSION INDICATOR
62	P0457062	THREADED PLATE
63	P0457063	LOCK KNOB M8-1.25 X 45
64	P0457064	KNOB M8-1.25
65	PW03M	FLAT WASHER 6MM
66	P0457066	PULL NUT M8-1.25
67	P0457067	BRACKET

REF	PART #	DESCRIPTION
68	P0457068	SQUARE SHAFT 12 X 12MM
69	PCAP14M	CAP SCREW M8-1.25 X 20
70	PLW04M	LOCK WASHER 8MM
71	PW01M	FLAT WASHER 8MM
72	P0457072	SLEEVE
73	P0457073	UPPER WHEEL SHAFT BRACKET
74	PRP91M	ROLL PIN 5 X 35
75	P0457075	UPPER WHEEL SHAFT
76	P0457076	WAVY WASHER 15 X 22MM
77	P0457077	UPPER WHEEL
78	P0457078	WHEEL TIRE
79	PB03M	HEX BOLT M8-1.25 X 16
80	PLW04M	LOCK WASHER 8MM
81	PW01M	FLAT WASHER 8MM
82	P6202ZZ	BALL BEARING 6202ZZ
83	PR21M	INT RETAINING RING 35MM
86	PN15M	HEX NUT M18-1.5
87	PLW12M	LOCK WASHER 18MM
88	P0457088	LOWER WHEEL SHAFT
89	P0457089	LEFT BLADE COVER
90	PN03M	HEX NUT M8-1.25
91	PSS09M	SET SCREW M8-1.25 X 20
92	P0457092	SHAFT END CAP
93	PFS01M	FLANGE SCREW M5-.8 X 8
94	P0457094	DUST PORT
95	PFS11M	FLANGE SCREW M6-1 X 10
96V2	P0457096V2	MOTOR 2HP 1PH 220/110V V2.05.11
96V2-1	P0457096V2-1	MOTOR FAN COVER
96V2-2	P0457096V2-2	MOTOR FAN
96V2-3	P0457096V2-3	S CAPACITOR COVER
96V2-4	P0457096V2-4	S CAPACITOR 300M 250V
96V2-5	P0457096V2-5	MOTOR JUNCTION BOX
96V2-6	P0457096V2-6	CENTRIFUGAL SWITCH
96V2-7	P0457096V2-7	CONTACT PLATE
96V2-8	P0457096V2-8	FRONT MOTOR BEARING
96V2-9	P0457096V2-9	REAR MOTOR BEARING
96V2-10	P0457096V2-10	R CAPACITOR COVER
96V2-11	PC040F	R CAPACITOR 40M 250V 1-3/8 X 2-3/8
97	PK34M	KEY 5 X 5 X 20
100	PCAP02M	CAP SCREW M6-1 X 20
101	P0457101	WHEEL COVER LATCH KNOB 6MM
102	PLN03M	LOCK NUT M6-1
103	P0457103	ALIGNMENT PIN
104	PFS03M	FLANGE SCREW M5-.8 X 6
105	P0457105	RIGHT BLADE COVER
111	P0457111	POINTER
112	PB02M	HEX BOLT M6-1 X 12
113	PW01M	FLAT WASHER 8MM
114	PLW04M	LOCK WASHER 8MM
115	PCAP14M	CAP SCREW M8-1.25 X 20
116	P0457116	WHEEL BRUSH
117	PFS01M	FLANGE SCREW M5-.8 X 8
118	PB20M	HEX BOLT M8-1.25 X 35



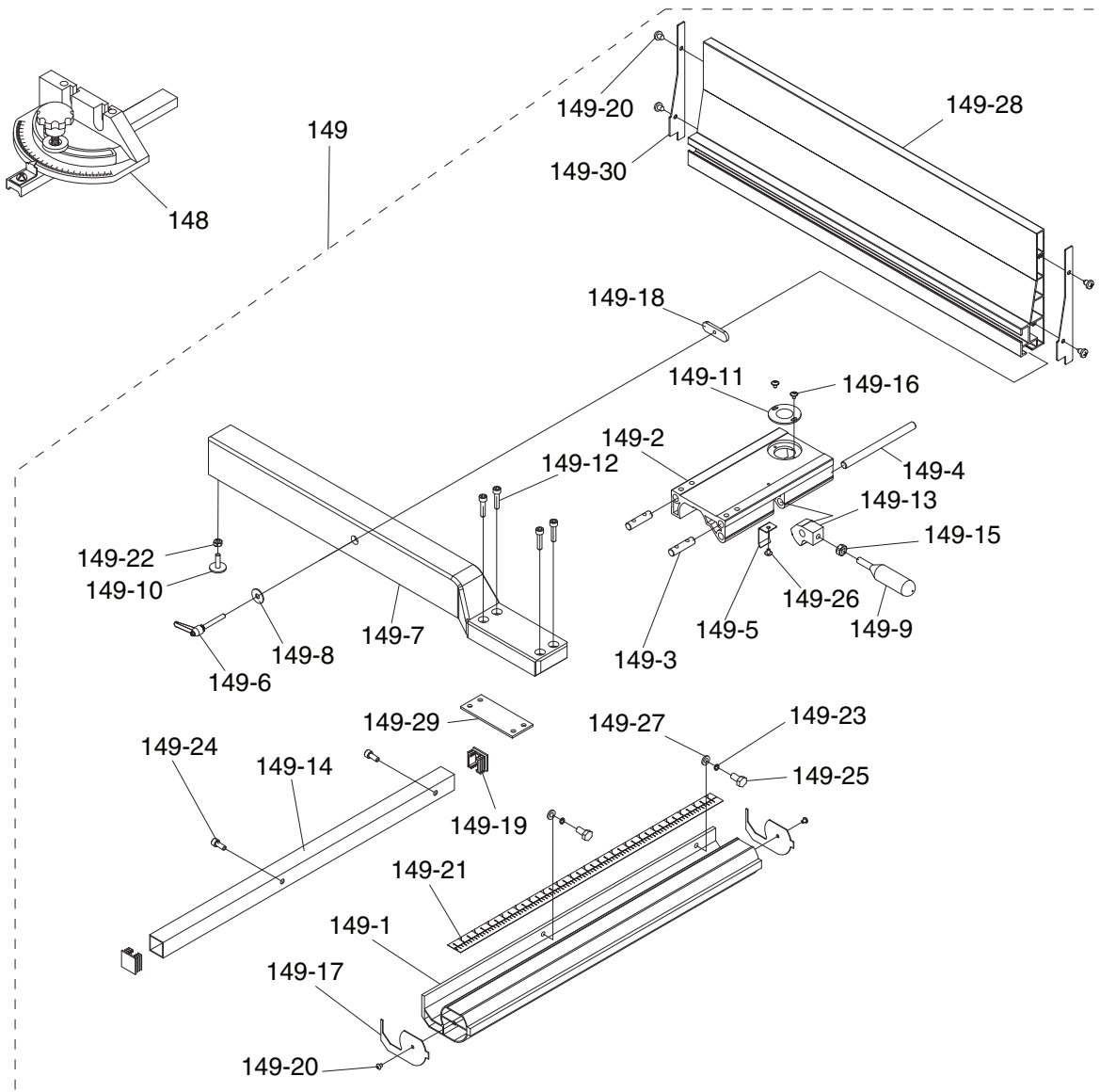
Main Parts List (Continued)

REF	PART #	DESCRIPTION
119	PLW04M	LOCK WASHER 8MM
120A	P0457120A	TRUNNION BRACKET, CAST IRON
121	PB82M	HEX BOLT M8-1.25 X 80
122	PN03M	HEX NUT M8-1.25
123	P0457123	POINTER
124	PS19M	PHLP HD SCR M5-.8 X 6
125	P0457125	LOCK KNOB M10-1.5
126	P0513X127	TABLE INSERT
127	P0457127	TABLE PIN
128	P0457128	TABLE
129	PB73M	HEX BOLT M10-1.5 X 50
130	P0457130	TRUNNION CLAMP SHOE 1PC
131	P0457131	TRUNNION
132	P0457132	SCALE
133	PFB01M	FLANGE BOLT M6-1 X 12
134	P0457134	BLADE 106 X 3/8 X 0.35" 6TPI
135	PFS01M	FLANGE SCREW M5-.8 X 8
136	PS38M	PHLP HD SCR M4-.7 X 10
137	PS08M	PHLP HD SCR M5-.8 X 12
138	PTLW02M	EXT TOOTH WASHER 5MM
139	PN06M	HEX NUT M5-.8

REF	PART #	DESCRIPTION
140V2	P0457140V2	POWER CORD 14G 3C 6-15 V2.05.11
141	P0457141	MOTOR CORD 14G 3C
142	PFS01M	FLANGE SCREW M5-.8 X 8
143	P0457143	STRAIN RELIEF
144	P0457144	SWITCH BOX REAR PLATE
145	P0457145	SWITCH BOX FRONT PLATE
146V2	P0555014V2	ON/OFF SWITCH 110/220V V2.05.11
150	P0457150	POINTER BRACKET
151	PFS12M	FLANGE SCREW M5-.8 X 12
157	P0457157	LEVER PLATE
158	PB09M	HEX BOLT M8-1.25 X 20
159	PLW04M	LOCK WASHER 8MM
160	PW01M	FLAT WASHER 8MM
161	P0457161	SHIM PLASTIC
162	PSS02M	SET SCREW M6-1 X 6
164	PSS16M	SET SCREW M8-1.25 X 10
201	P0457201	WHEEL LOWER ASSEMBLY
202	P0457202	RIBBED BELT 200J5
203	P0457203	MOTOR PULLEY
204	PSS01M	SET SCREW M6-1 X 10



Components

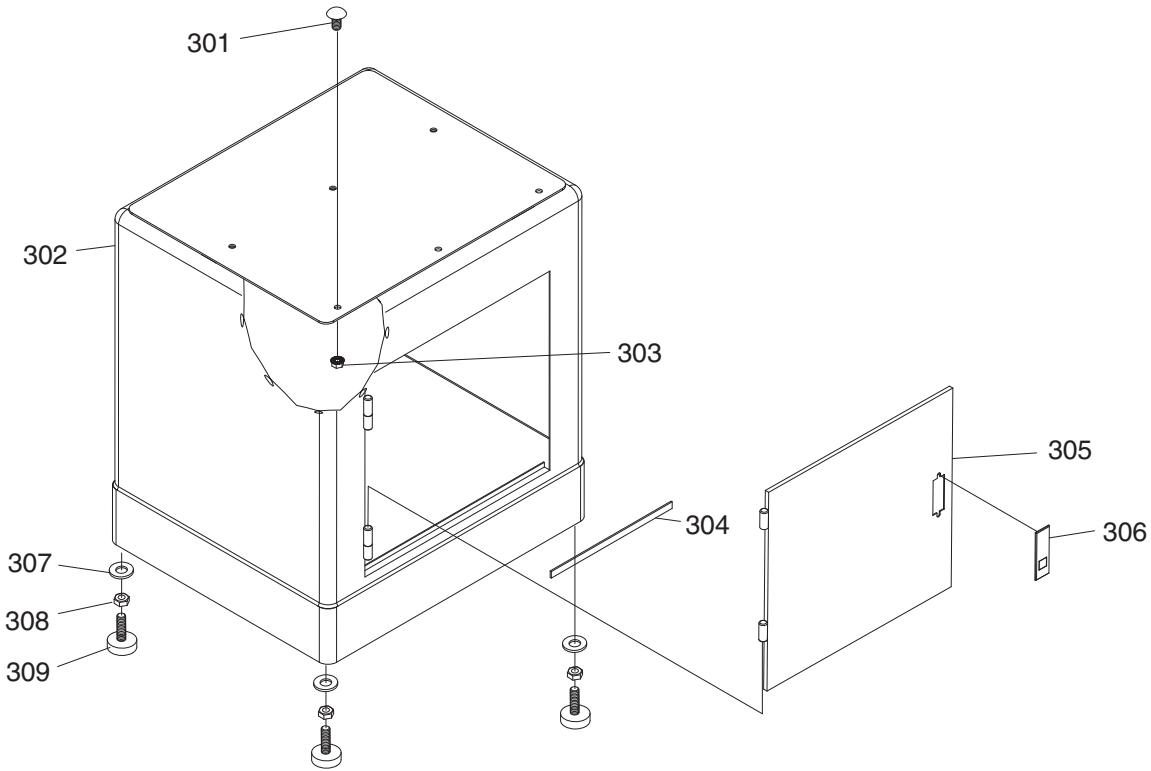


REF	PART #	DESCRIPTION
148	P0457148	MITER GAUGE ASSEMBLY
149	H7587	RESAW FENCE ASSEMBLY
149-1	PH7587001	FRONT FENCE RAIL 540MM
149-2	PH7587002	FENCE BASE
149-3	PH7587003	FENCE SUPPORT MOUNTING ROD
149-4	PH7587004	LOCK ROD
149-5	PH7587005	SPRING PIECE
149-6	PH7584004	LOCK HANDLE ASSEMBLY M8-1.25 X 44
149-7	PH7587007	FENCE SUPPORT 505MM
149-8	PW01M	FLAT WASHER 8MM
149-9	PH7587009	LOCK HANDLE
149-10	PH7587010	FENCE REAR STANDOFF
149-11	PH7587011	SCALE WINDOW
149-12	PCAP06M	CAP SCREW M6-1 X 25
149-13	PH7587013	LOCK CAM
149-14	PH7587014	REAR FENCE RAIL

REF	PART #	DESCRIPTION
149-15	PN03M	HEX NUT M8-1.25
149-16	PFS04M	FLANGE SCREW M4-.7 X 6
149-17	P0457149-17	FRONT RAIL END CAP
149-18	PH7528002	FENCE MOUNTING PLATE
149-19	P0457149-19	REAR RAIL END CAP
149-20	PHTEK3M	TAP SCREW M3.5 X 8
149-21	P0457149-21	SCALE
149-22	PN01M	HEX NUT M6-1
149-23	PLW03M	LOCK WASHER 6MM
149-24	PCAP01M	CAP SCREW M6-1 X 16
149-25	PB08M	HEX BOLT M6-1 X 20
149-26	PFS17M	FLANGE SCREW M4-.7 X 8
149-27	PW03M	FLAT WASHER 6MM
149-28	PH7528001	FENCE 505MM ALUMINUM
149-29	P0555306	FENCE SUPPORT MOUNTING PLATE
149-30	P0457149-30	FENCE END CAP



Stand

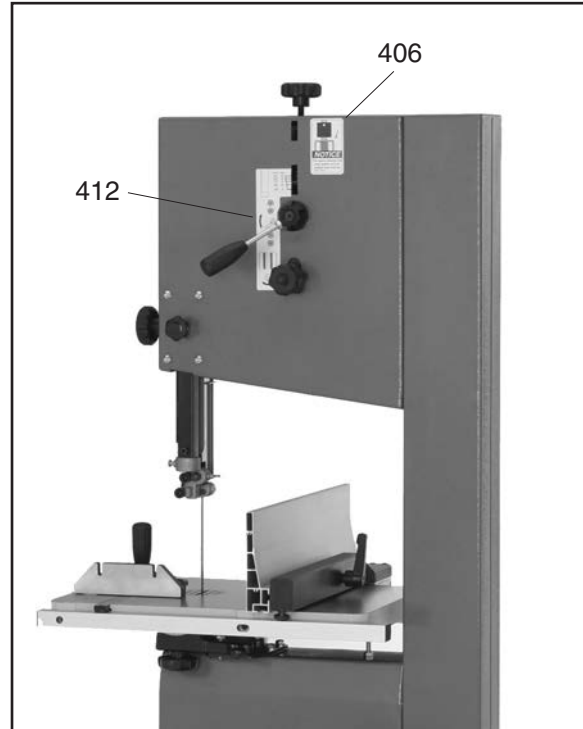
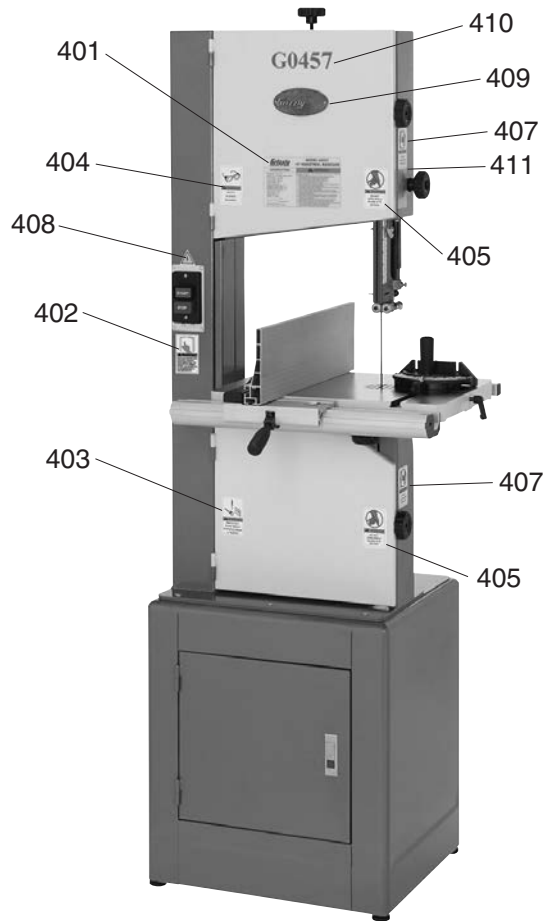


REF	PART #	DESCRIPTION
301	PCB01M	CARRIAGE BOLT M8-1.25 X 20
302	P0457302	STAND
303	P0457303	FLANGE NUT M8-1.25
304	P0457304	FOAM TAPE
305	P0457305	DOOR

REF	PART #	DESCRIPTION
306	P0457306	LATCH ASSEMBLY
307	PW02	FLAT WASHER 3/8
308	PN08	HEX NUT 3/8-16
309	P0457309	FOOT 3/8-16 X 1-3/4



Labels



Rear of Machine

REF	PART #	DESCRIPTION
401	P0457401	MACHINE ID LABEL
402	PLABEL-12	READ MANUAL LABEL
403	PLABEL-18	UNPLUG BANDSAW LABEL
404	PLABEL-11	SAFETY GLASSES LABEL
405	PLABEL-23	DO NOT OPEN LABEL
406	P0457406	BLADE TENSION NOTICE LABEL

REF	PART #	DESCRIPTION
407	PLABEL-19	HANDS NEAR BLADE LABEL
408	PLABEL-14	ELECTRICITY LABEL
409	G9987	GRIZZLY NAMEPLATE
410	P0457410	MODEL NUMBER LABEL
411	P0457411	BLADE GUARD ADJ LABEL
412	P0457412	BLADE TENSION SCALE/LABEL

WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____
 Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

2. Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	

3. What is your annual household income?

\$20,000-\$29,000 \$30,000-\$39,000 \$40,000-\$49,000
 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+

4. What is your age group?

20-29 30-39 40-49
 50-59 60-69 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times. Yes No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place Stamp Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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TOOL WEBSITE

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